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(54) **CARTRIDGE AND E-VAPING DEVICE**

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H05B 3/44 (2006.01)

(52) **U.S. Cl.**
CPC **A24F 47/008** (2013.01); **H05B 3/44**
(2013.01); **H05B 2203/003** (2013.01); **H05B**
2203/021 (2013.01)

(58) **Field of Classification Search**

None
See application file for complete search history.

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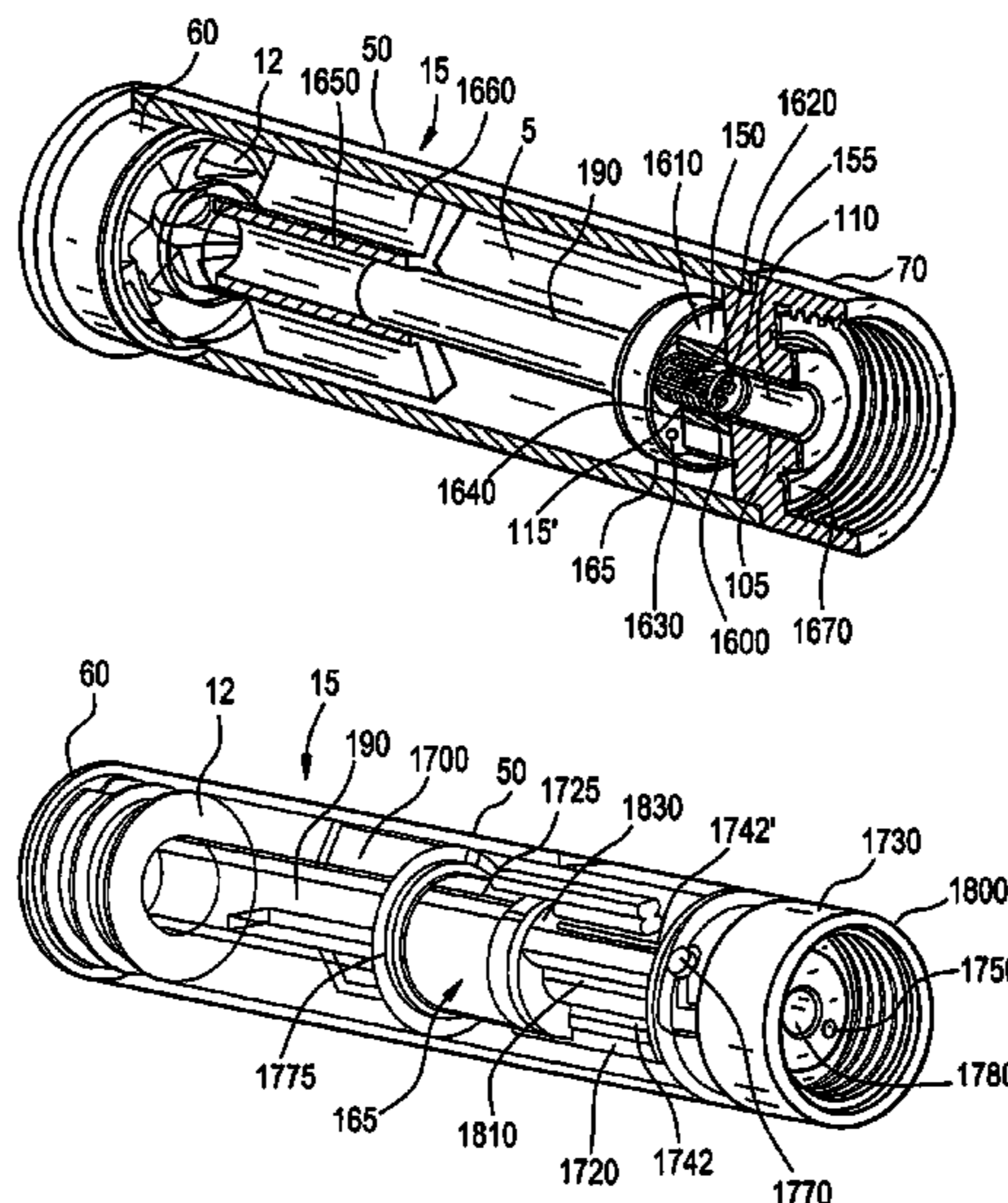
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(57) **ABSTRACT**

A cartridge of an e-vaping device includes a housing extend-
ing in a longitudinal direction, a reservoir in the housing, a
heater in the housing, and an absorbent material at least
partially surrounding the sinusoidal shaped member. The
reservoir is configured to store a pre-vapor formulation. The
heater has a sinusoidal shaped member translating about an
elliptical shape to define a channel there through. The
absorbent material is in fluid communication with the res-
ervoir.

21 Claims, 12 Drawing Sheets



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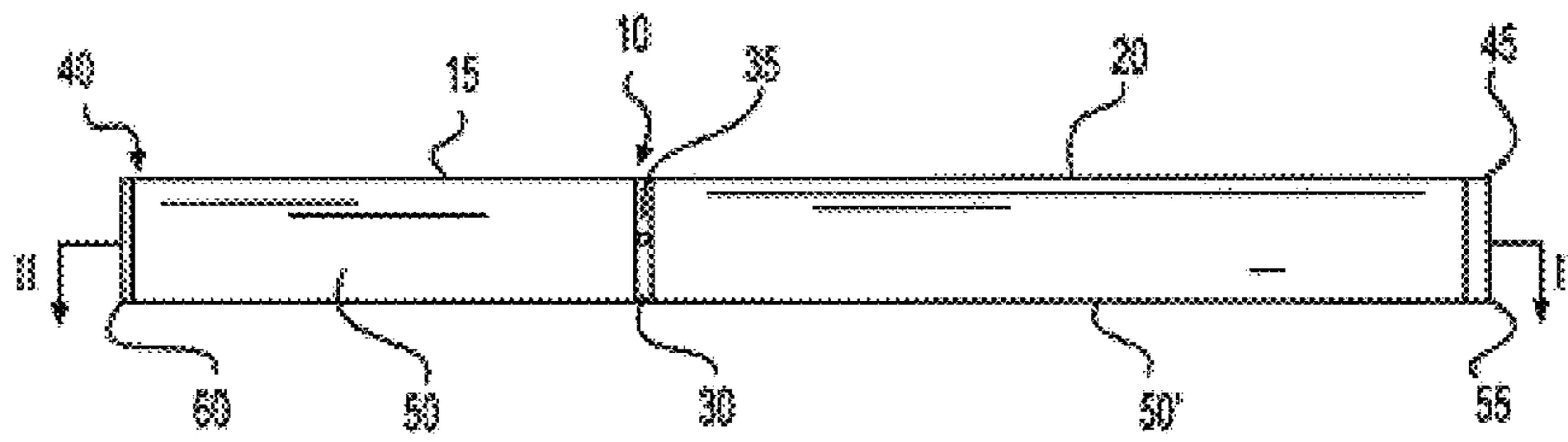


FIG. 1A

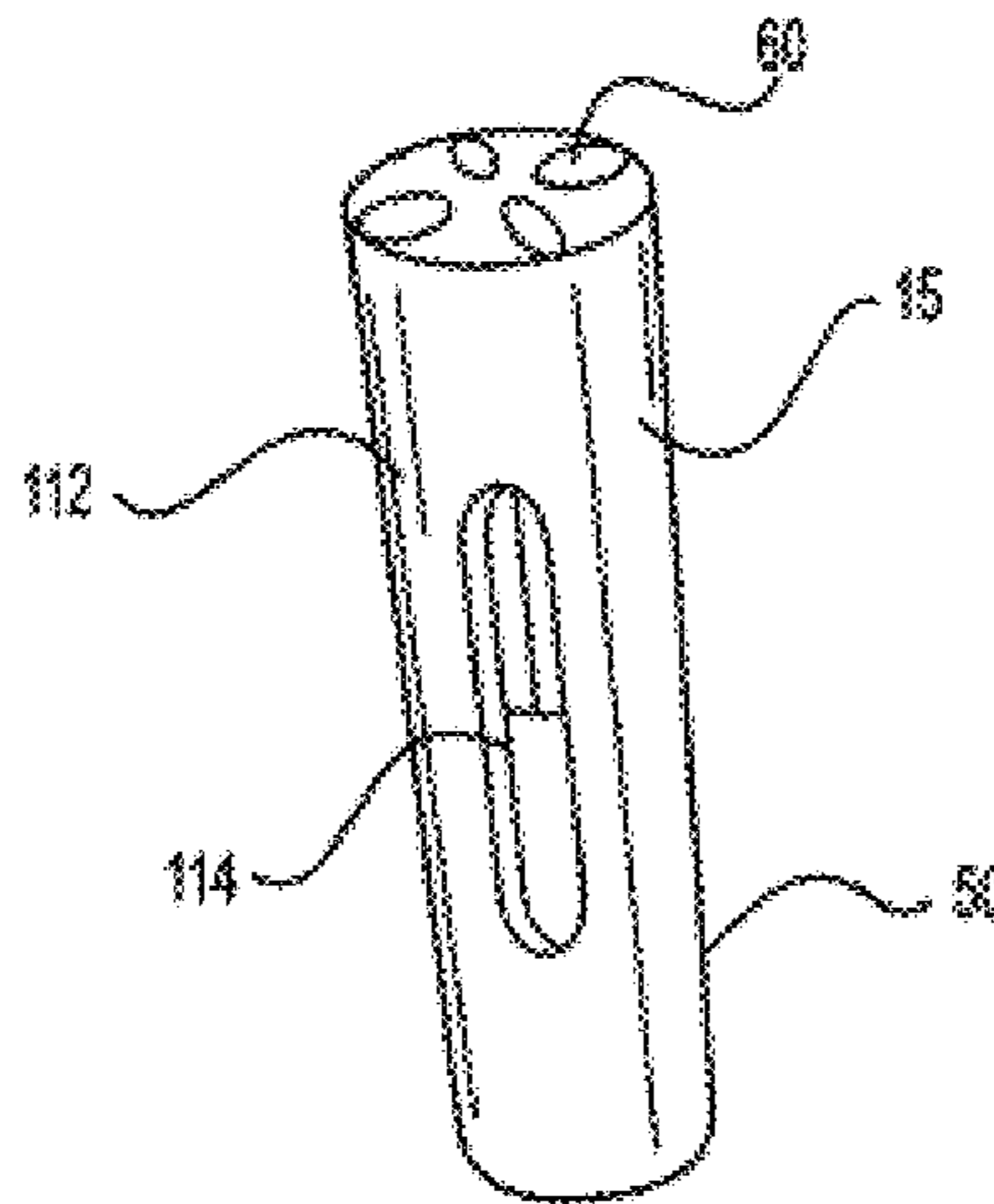


FIG. 1B

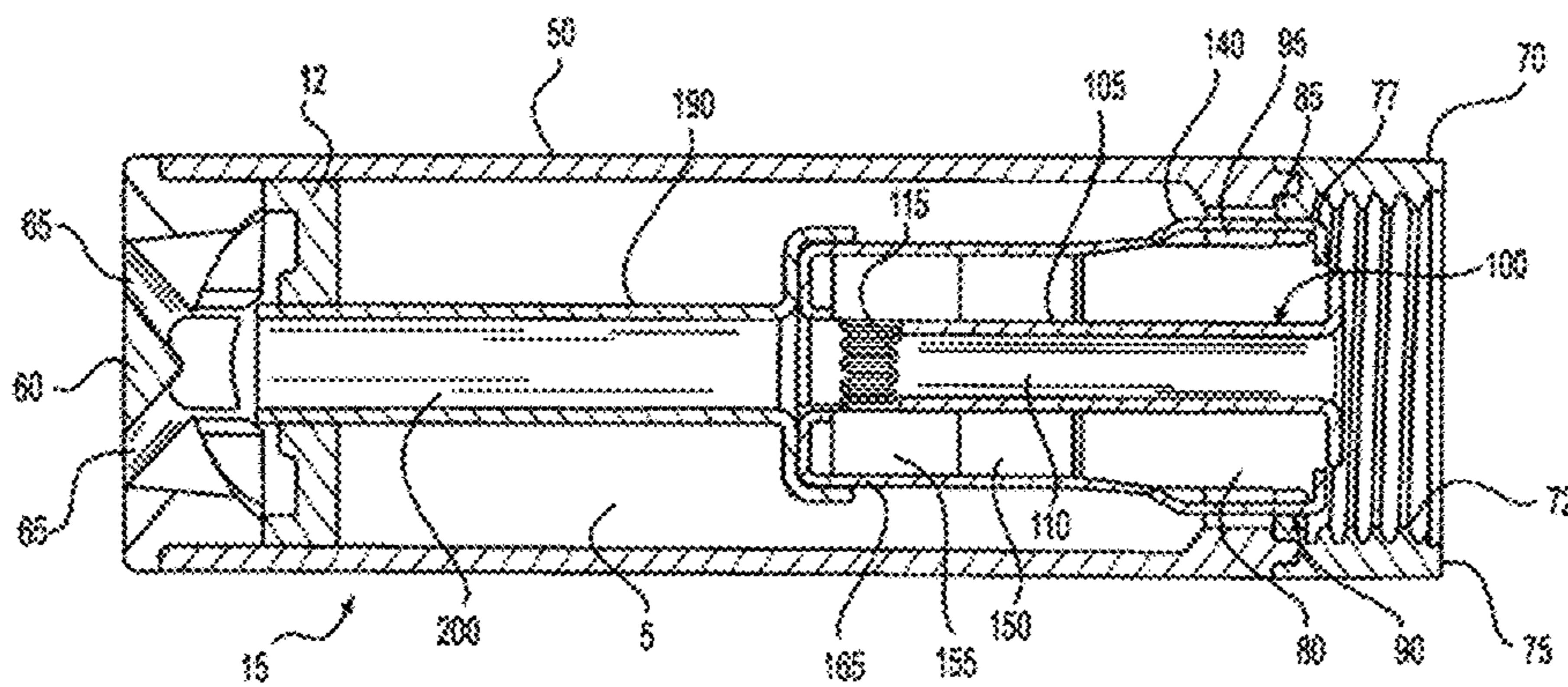


FIG. 2

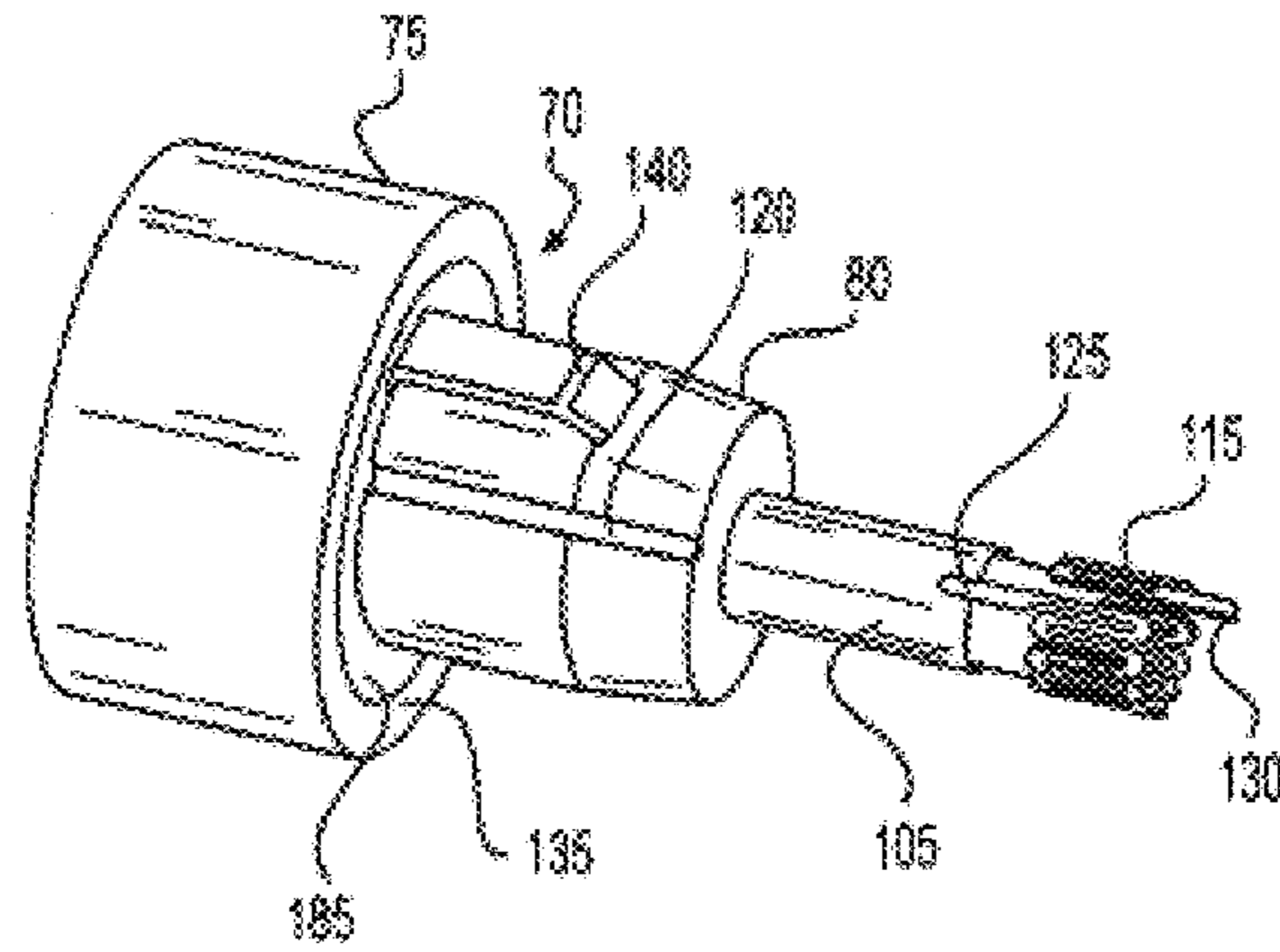


FIG. 3

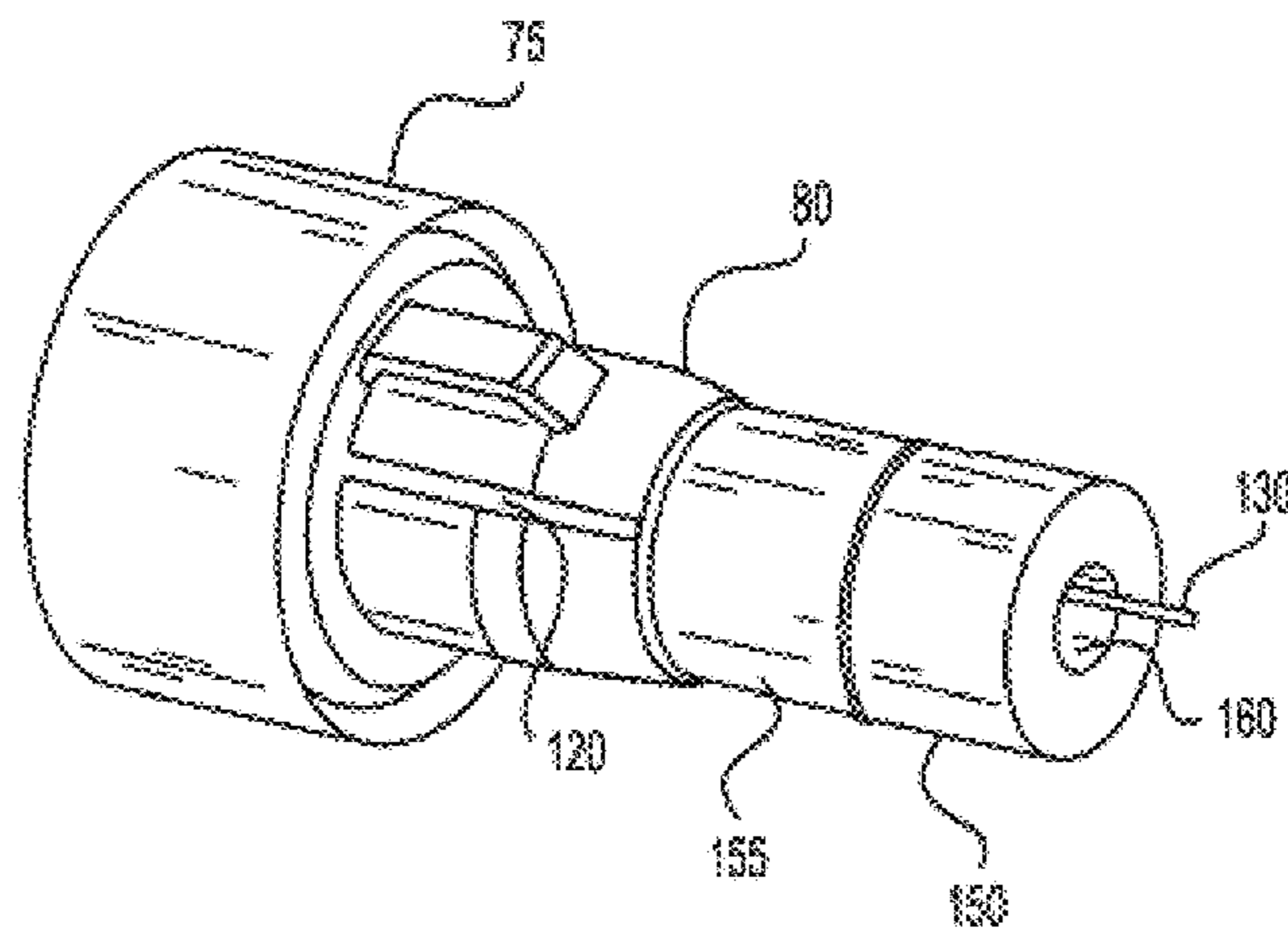


FIG. 4

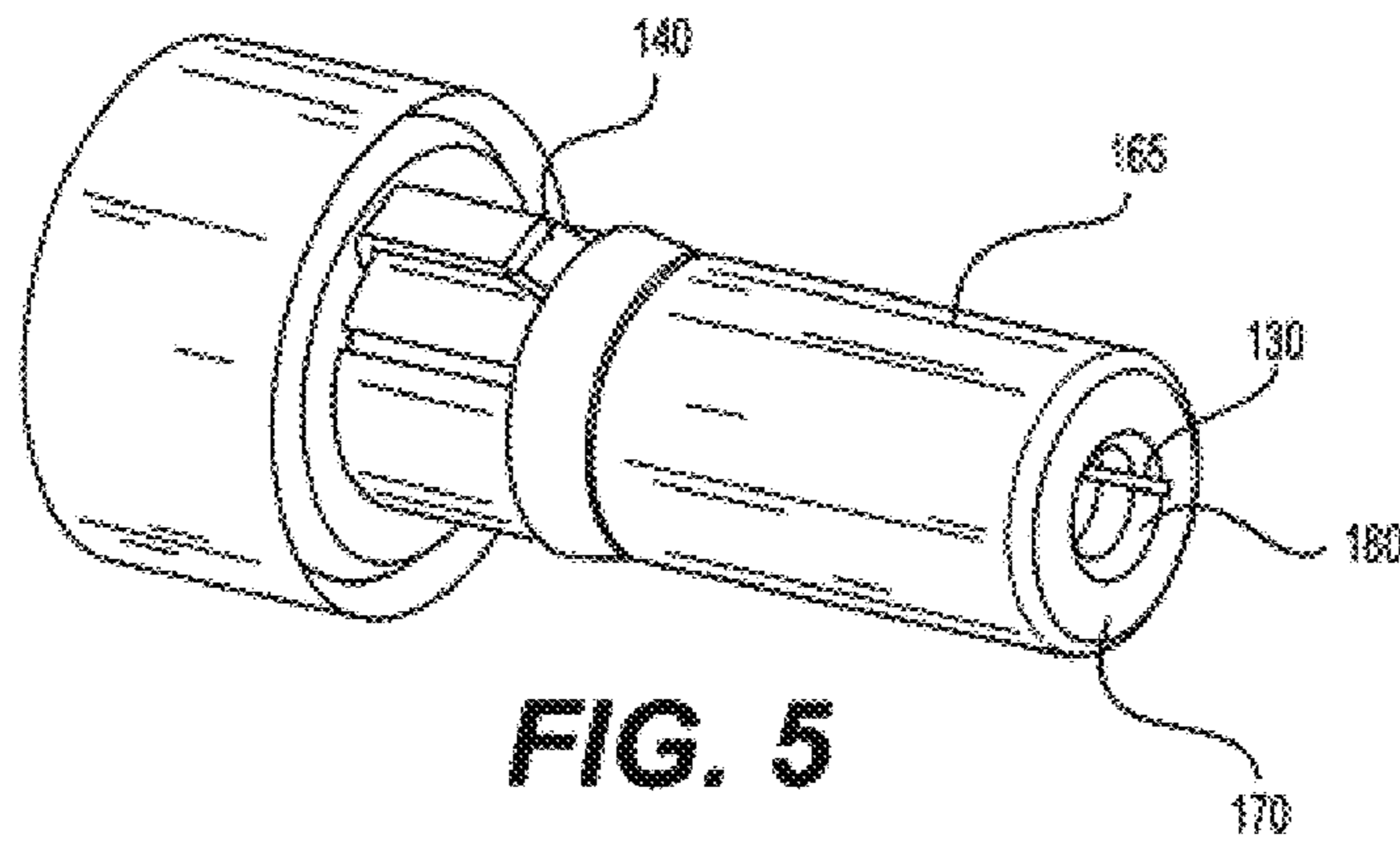


FIG. 5

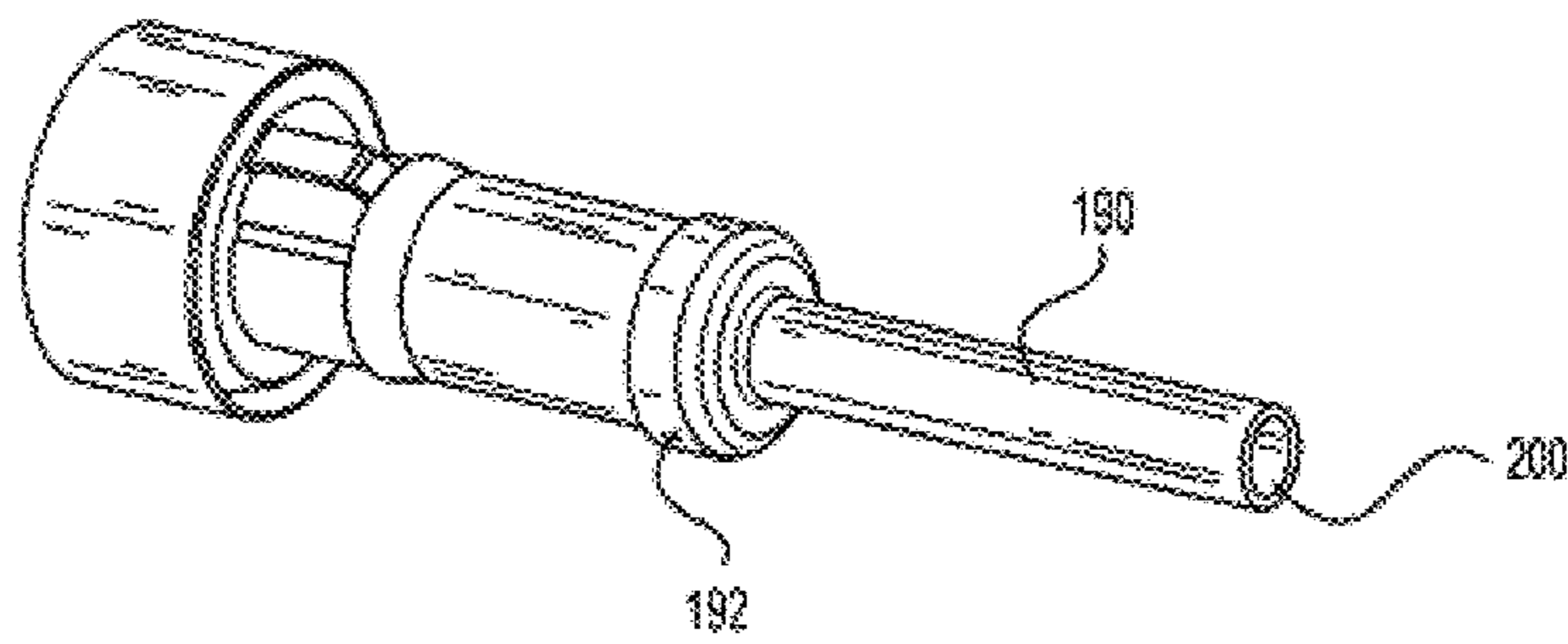


FIG. 6

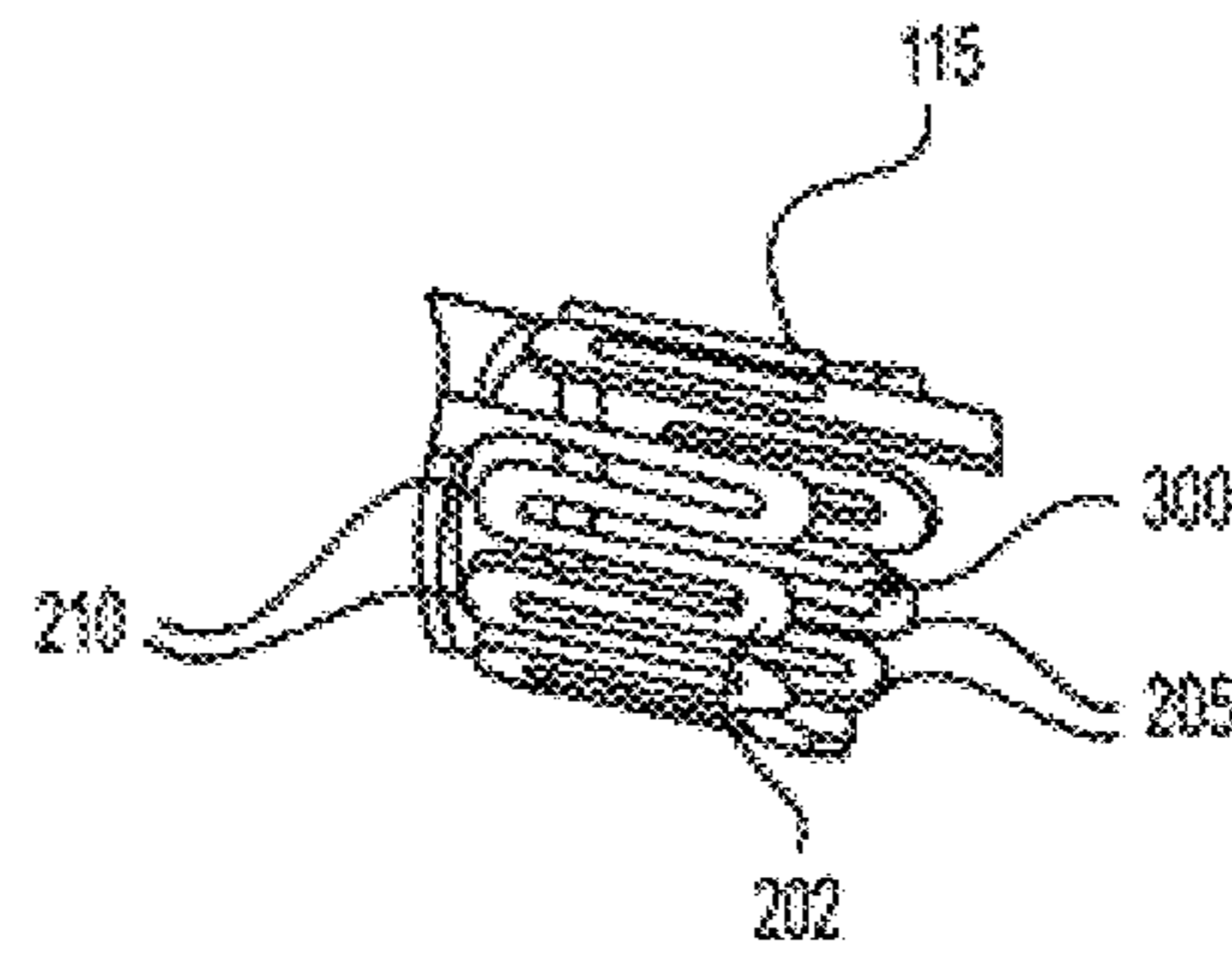


FIG. 7

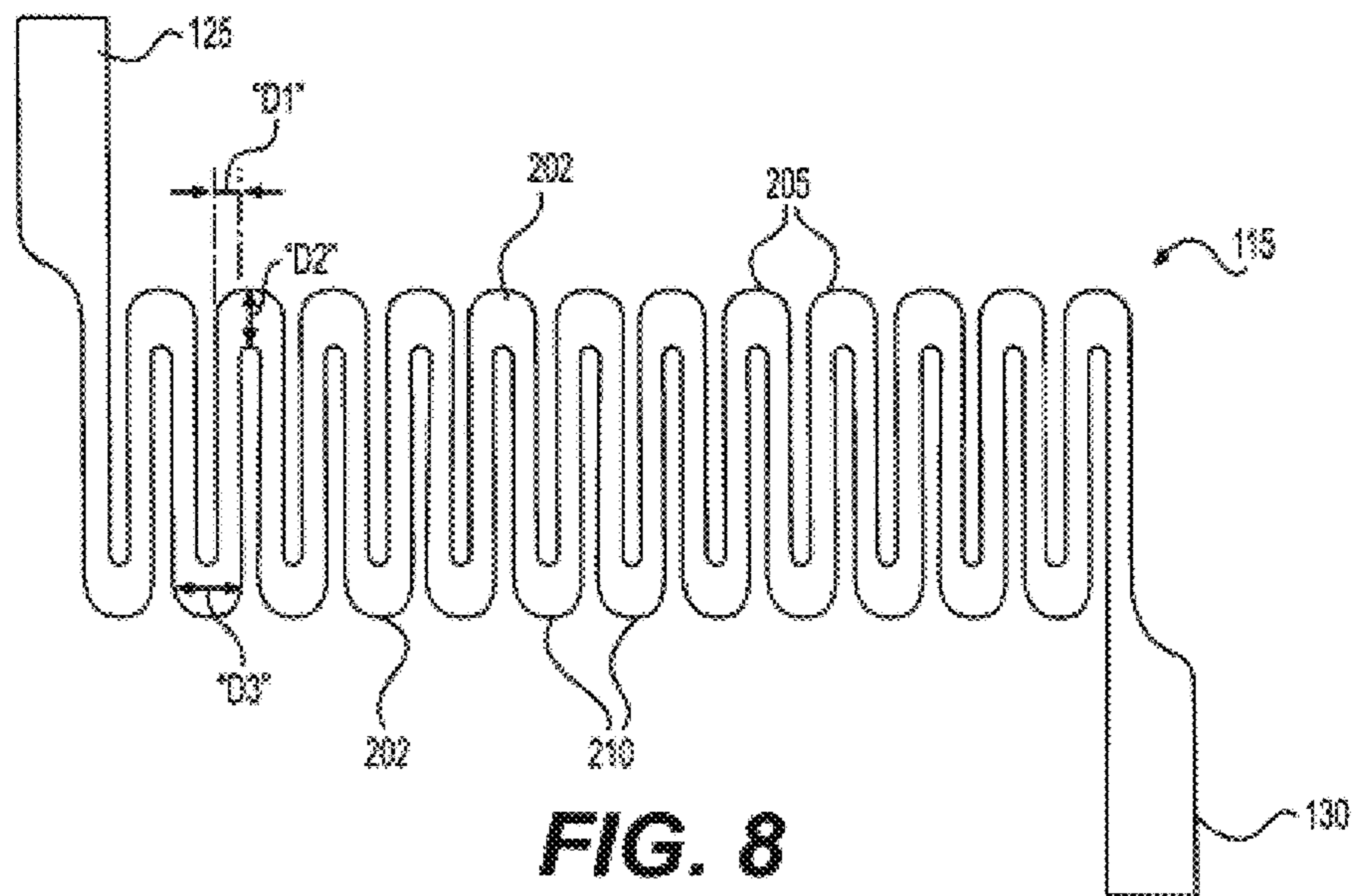
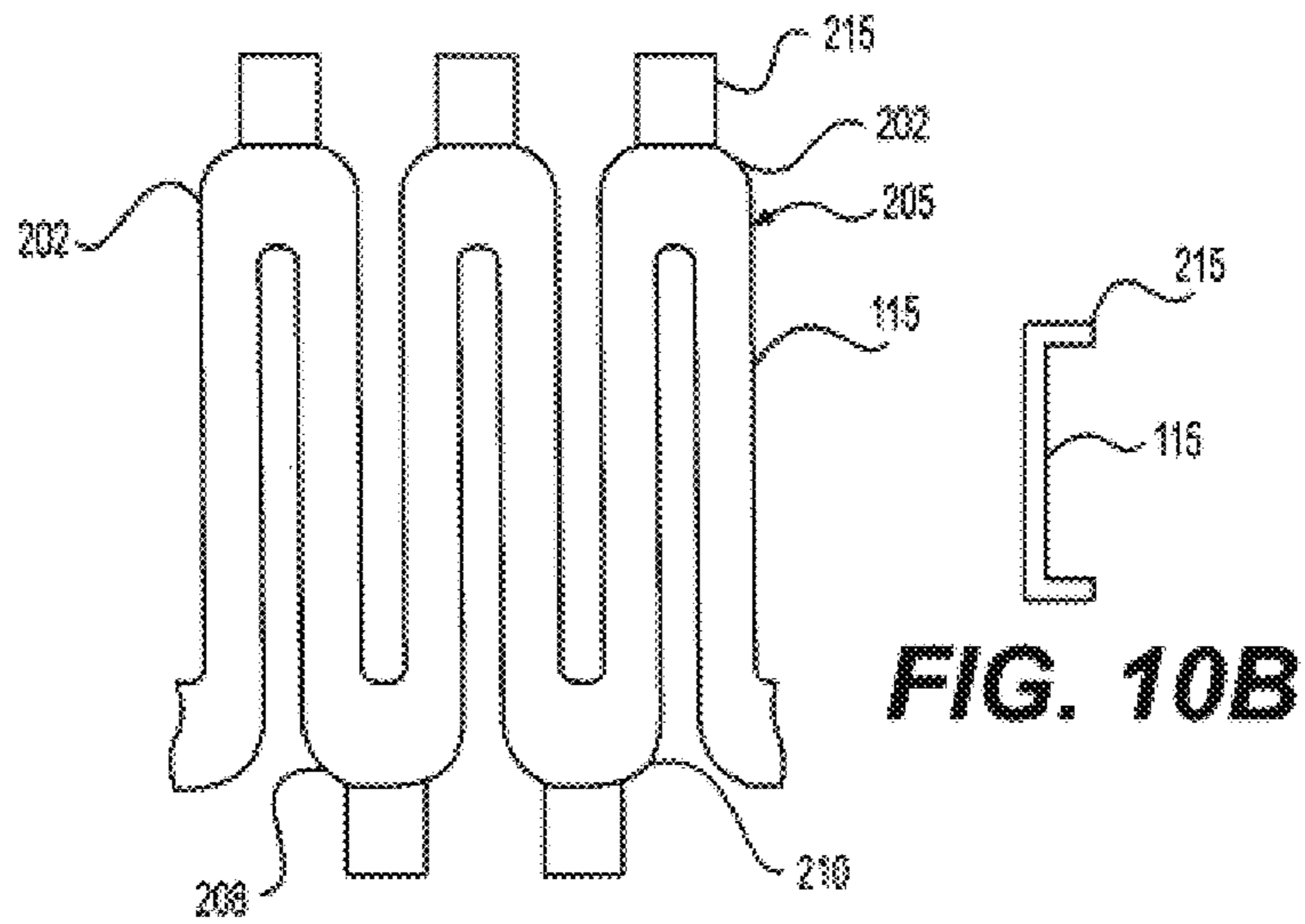
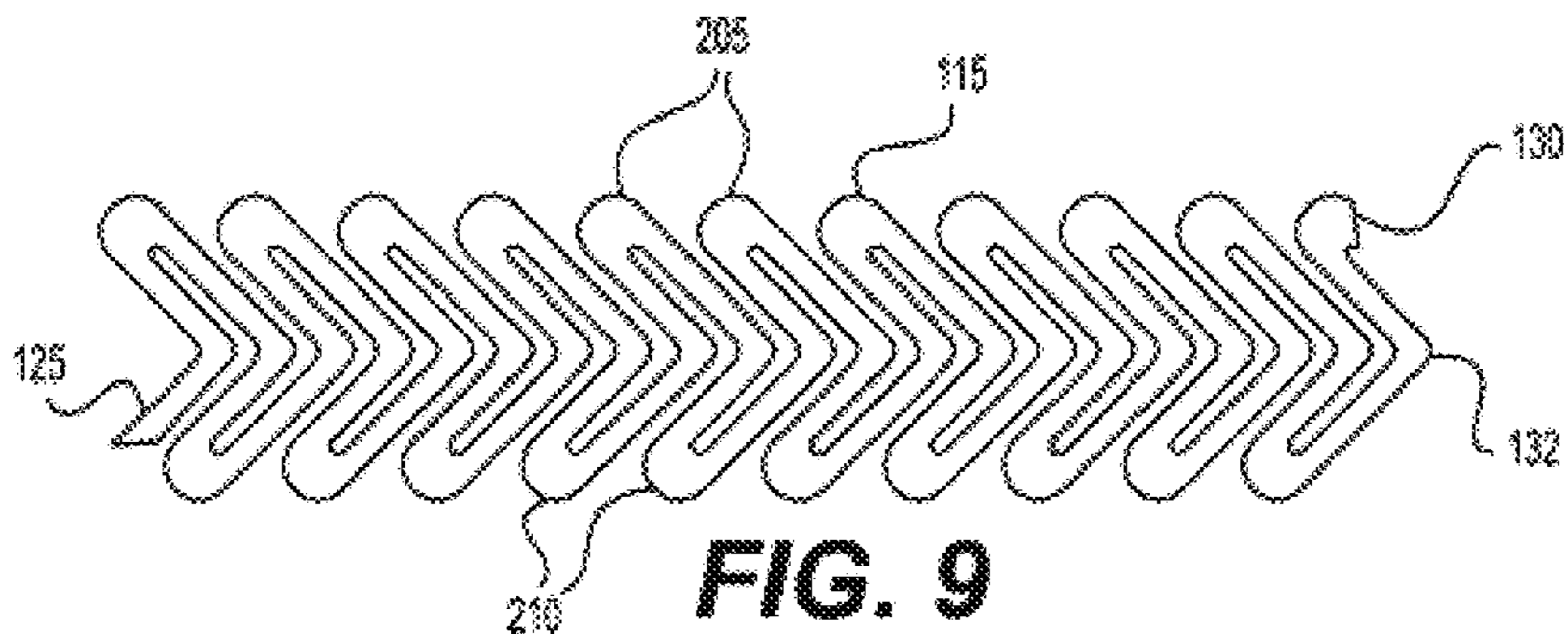
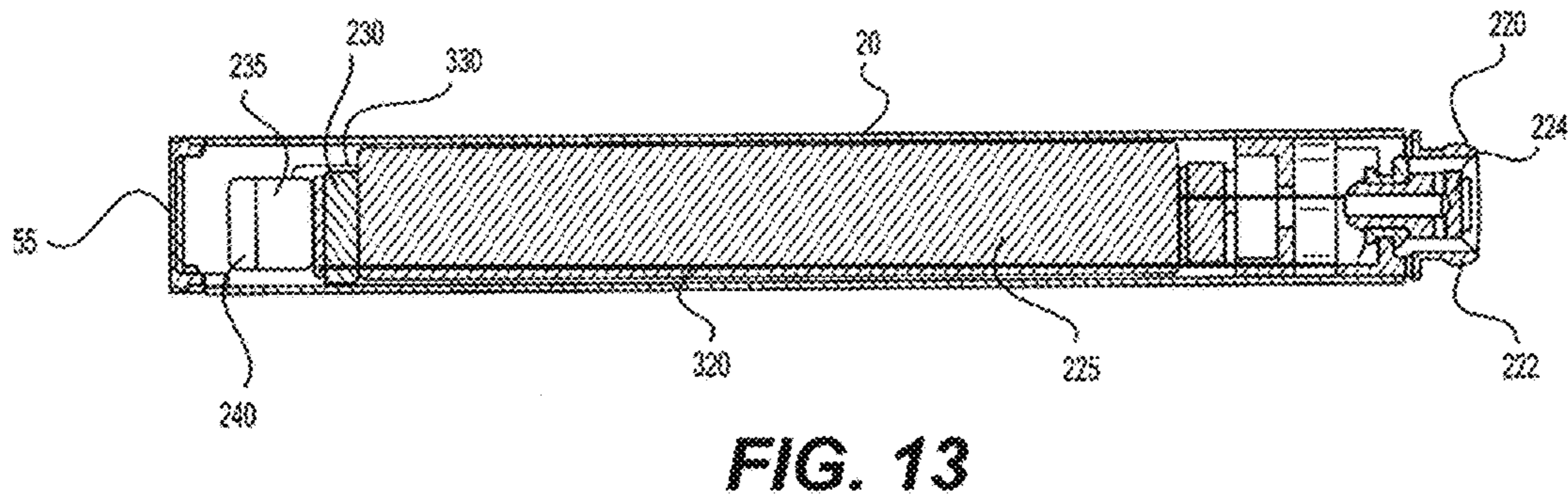
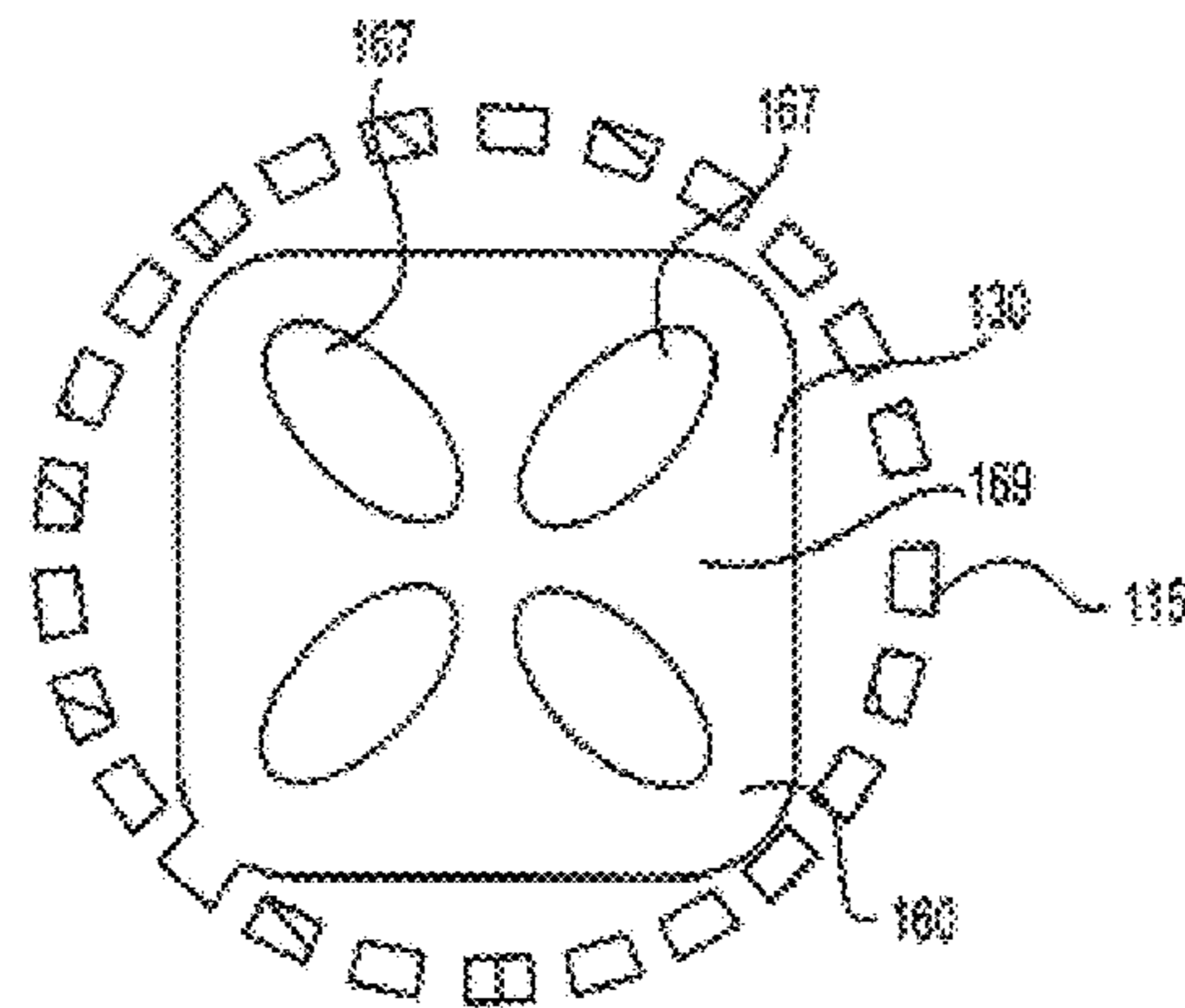
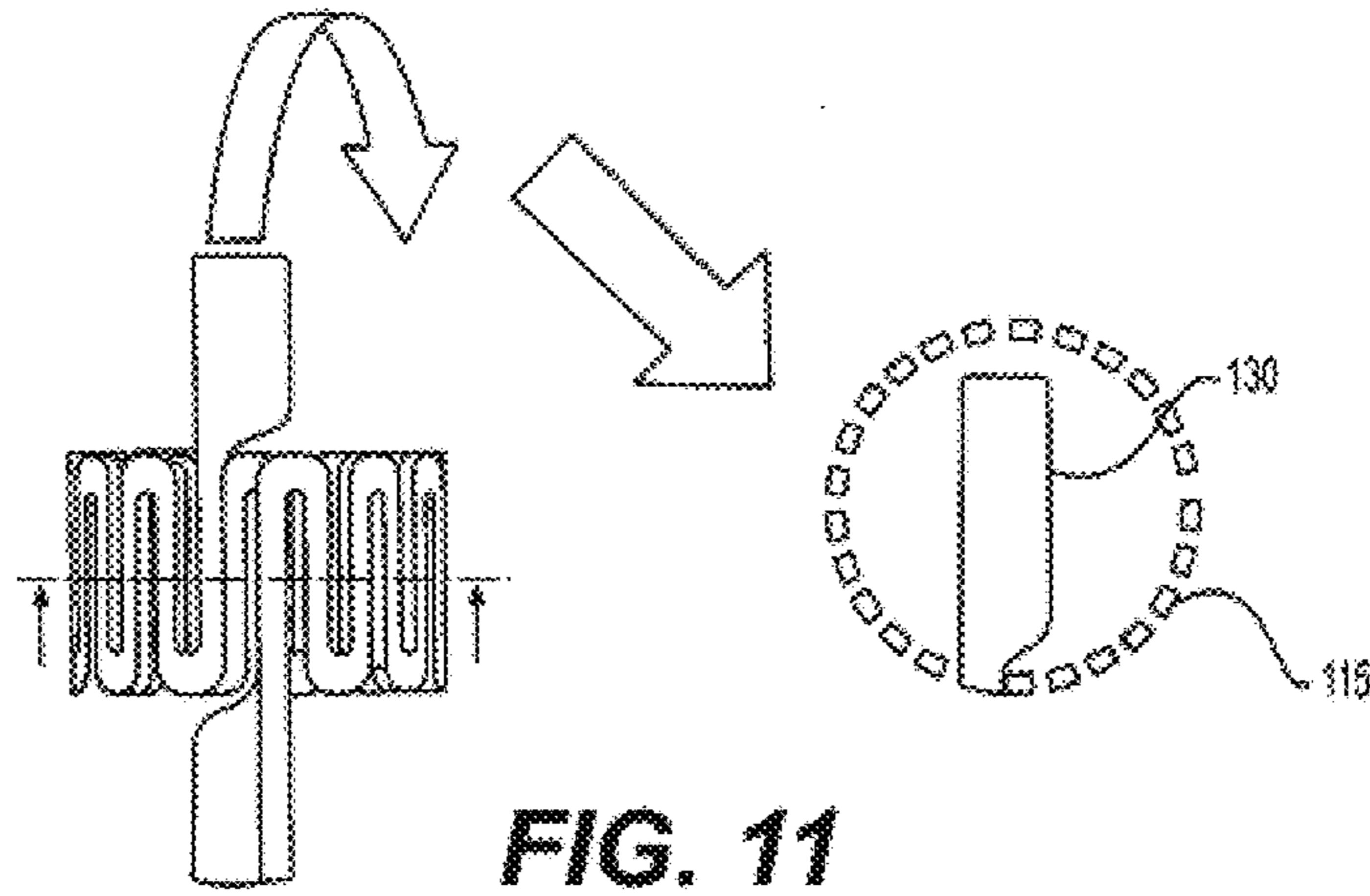


FIG. 8





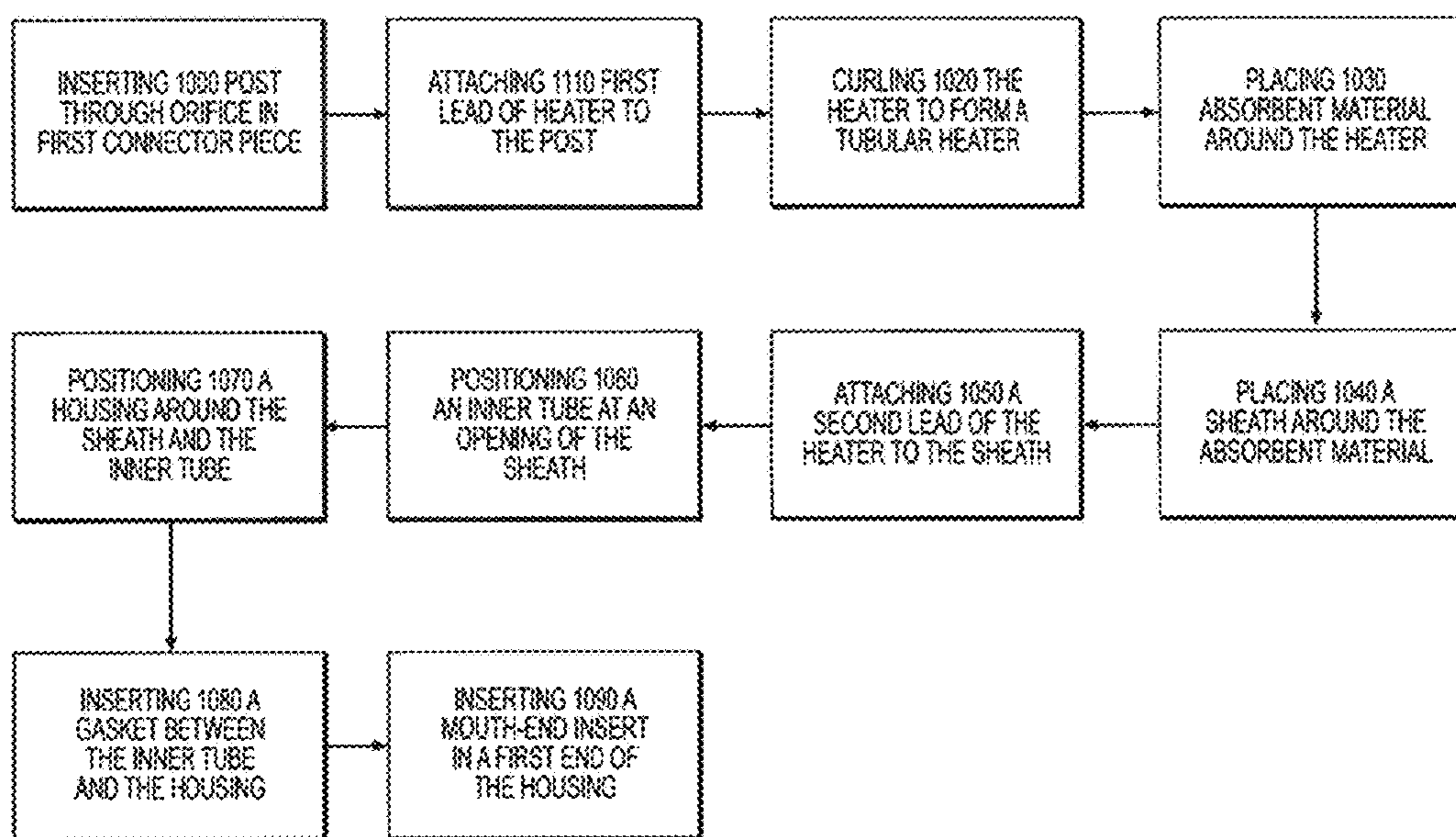


FIG. 14

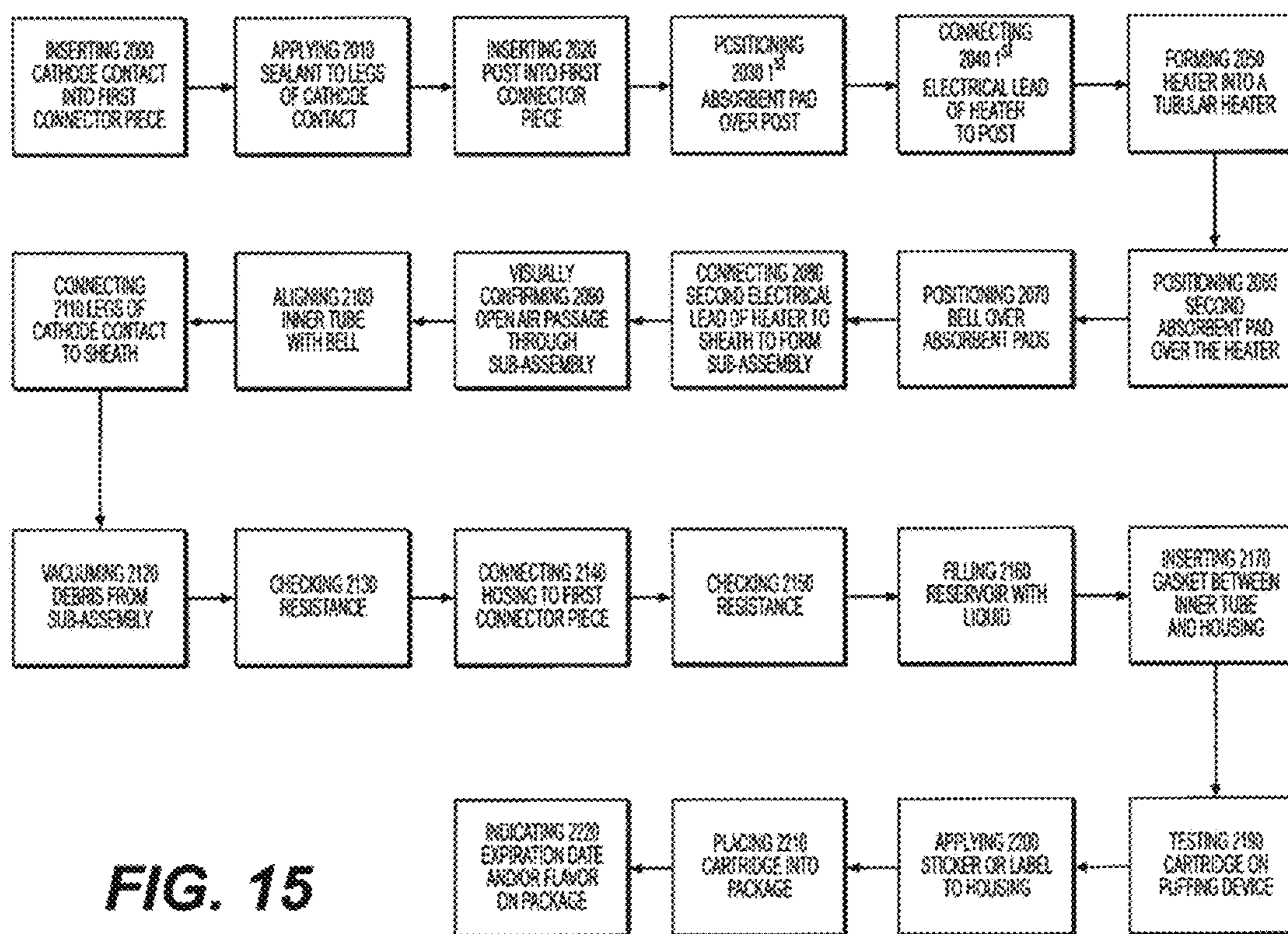


FIG. 15

FIG. 16

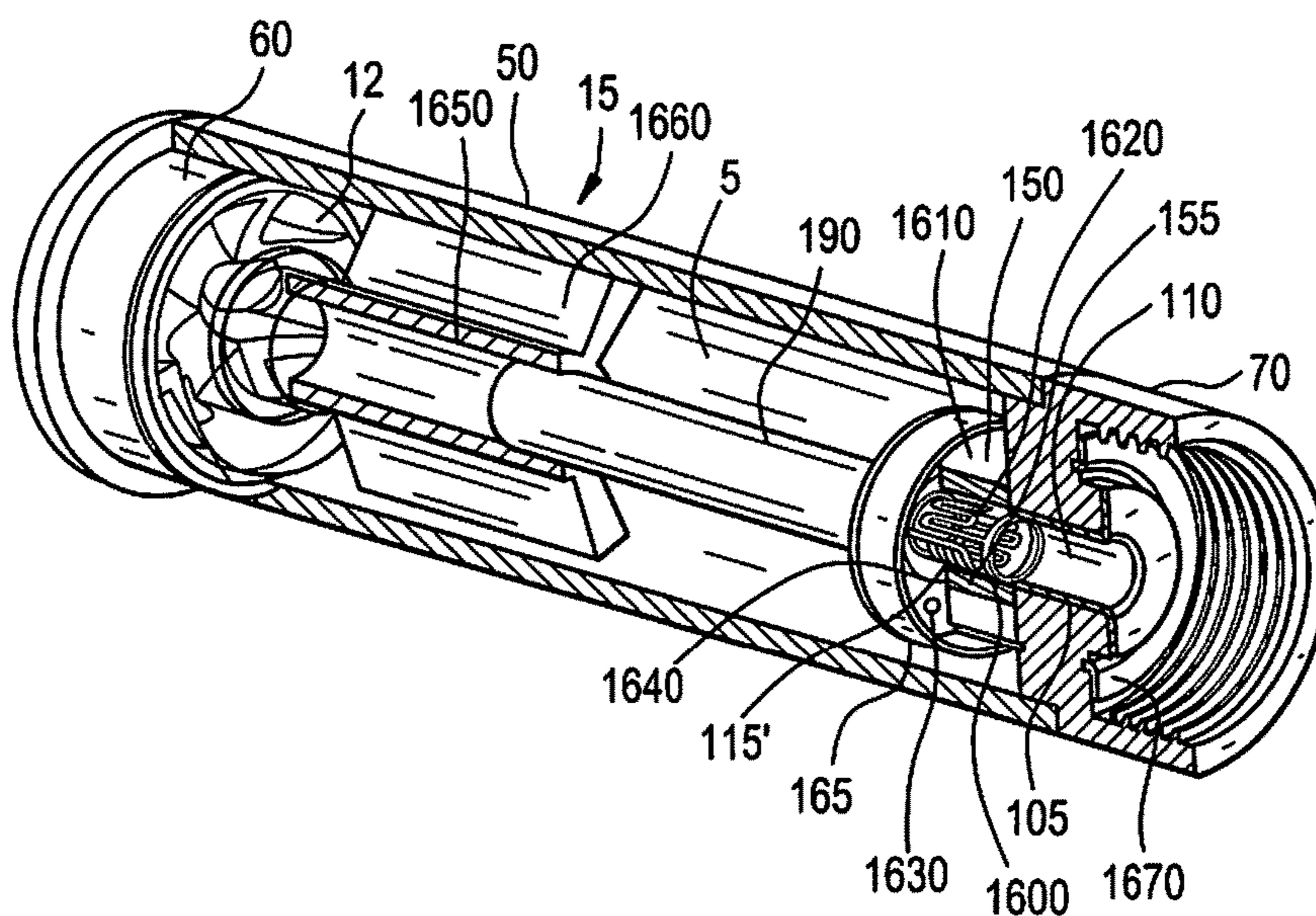


FIG. 17

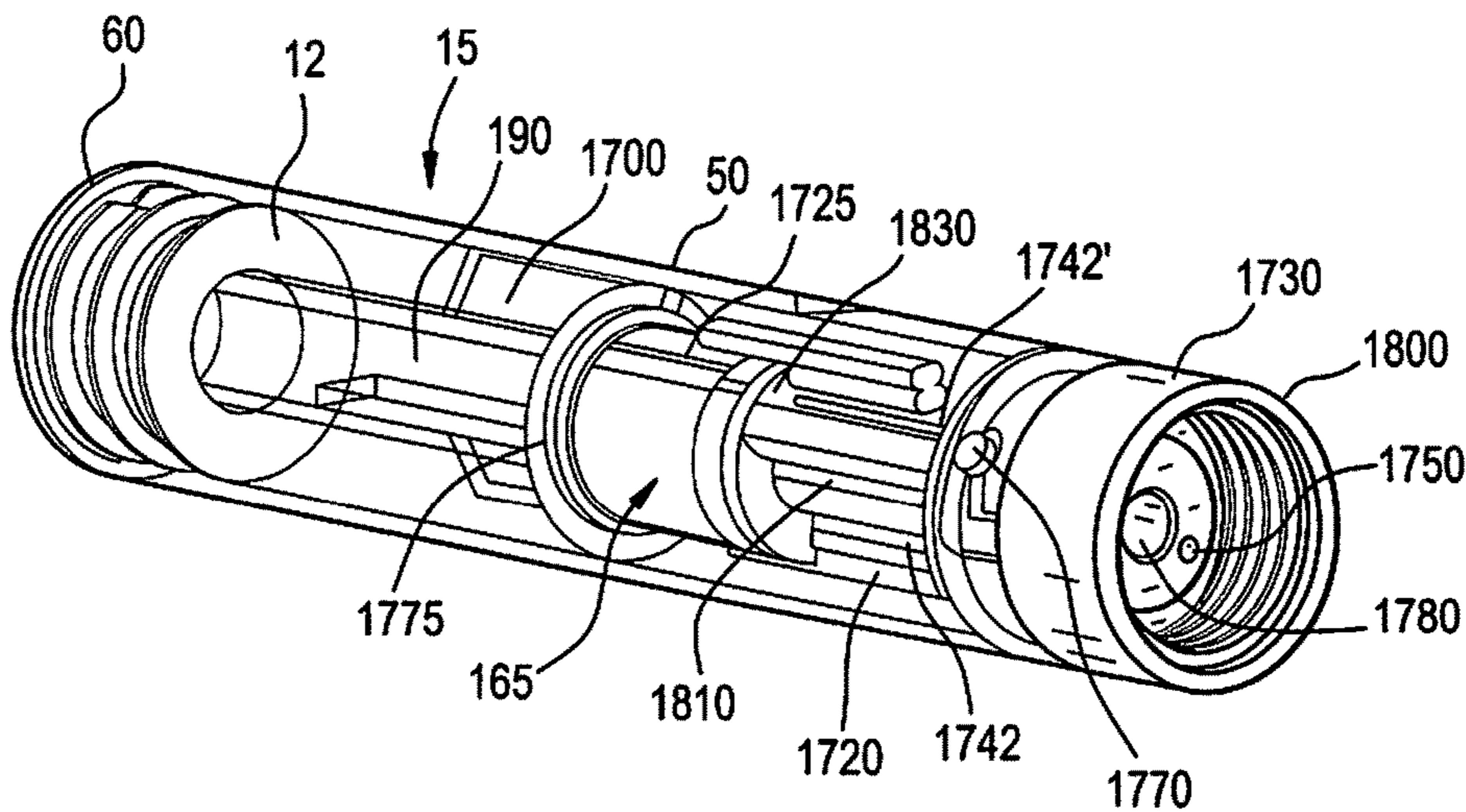


FIG. 18

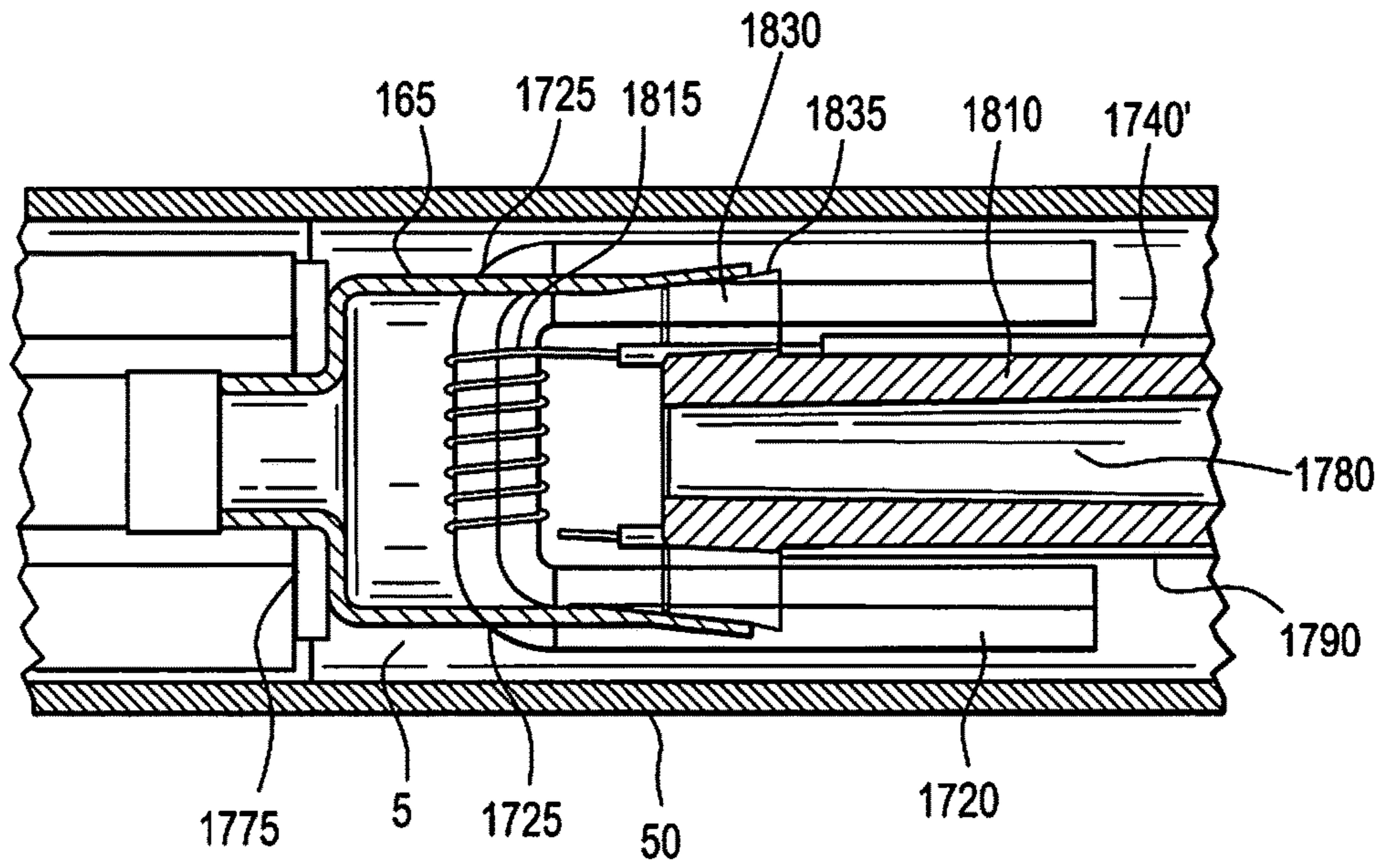


FIG. 19

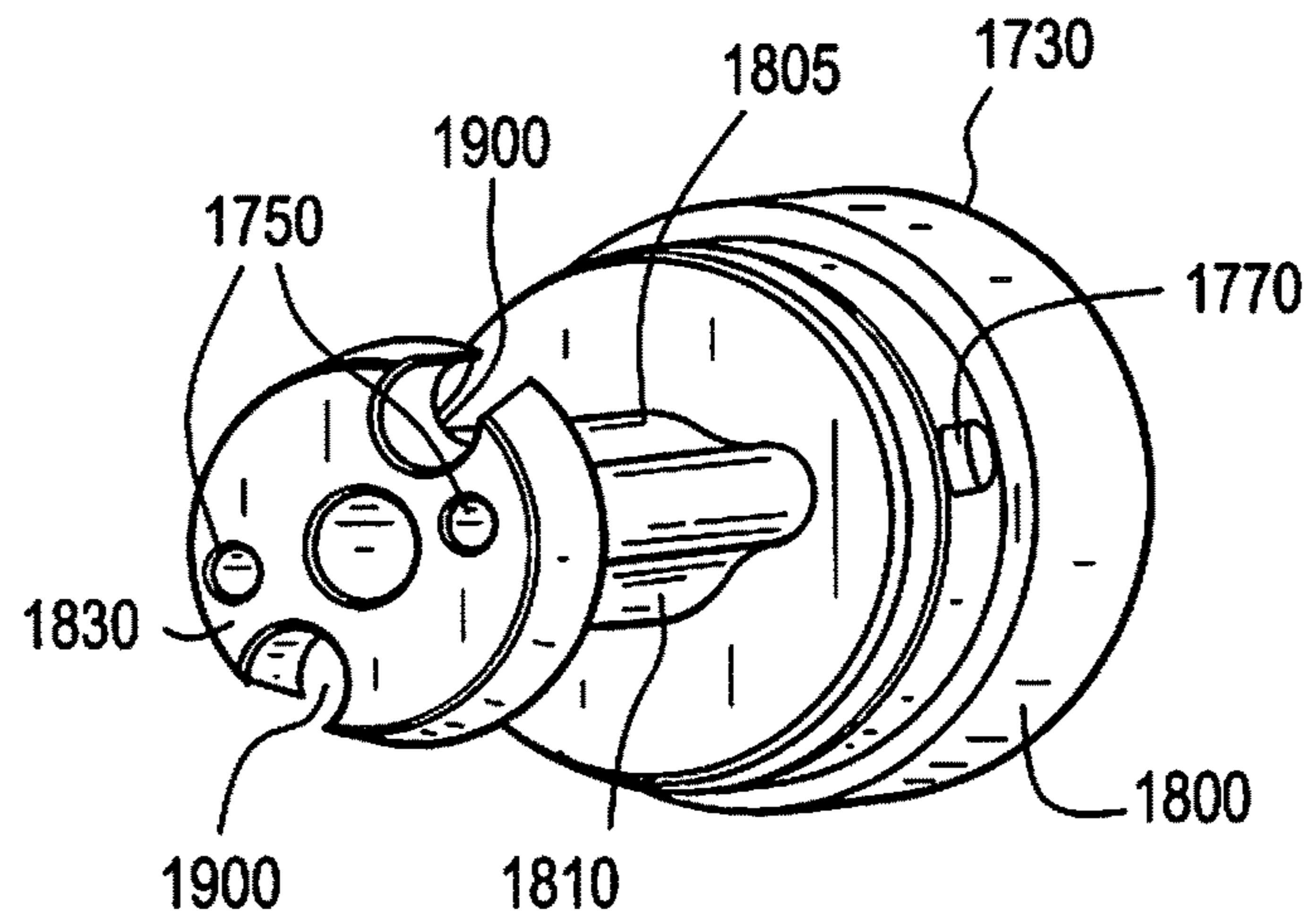


FIG. 20

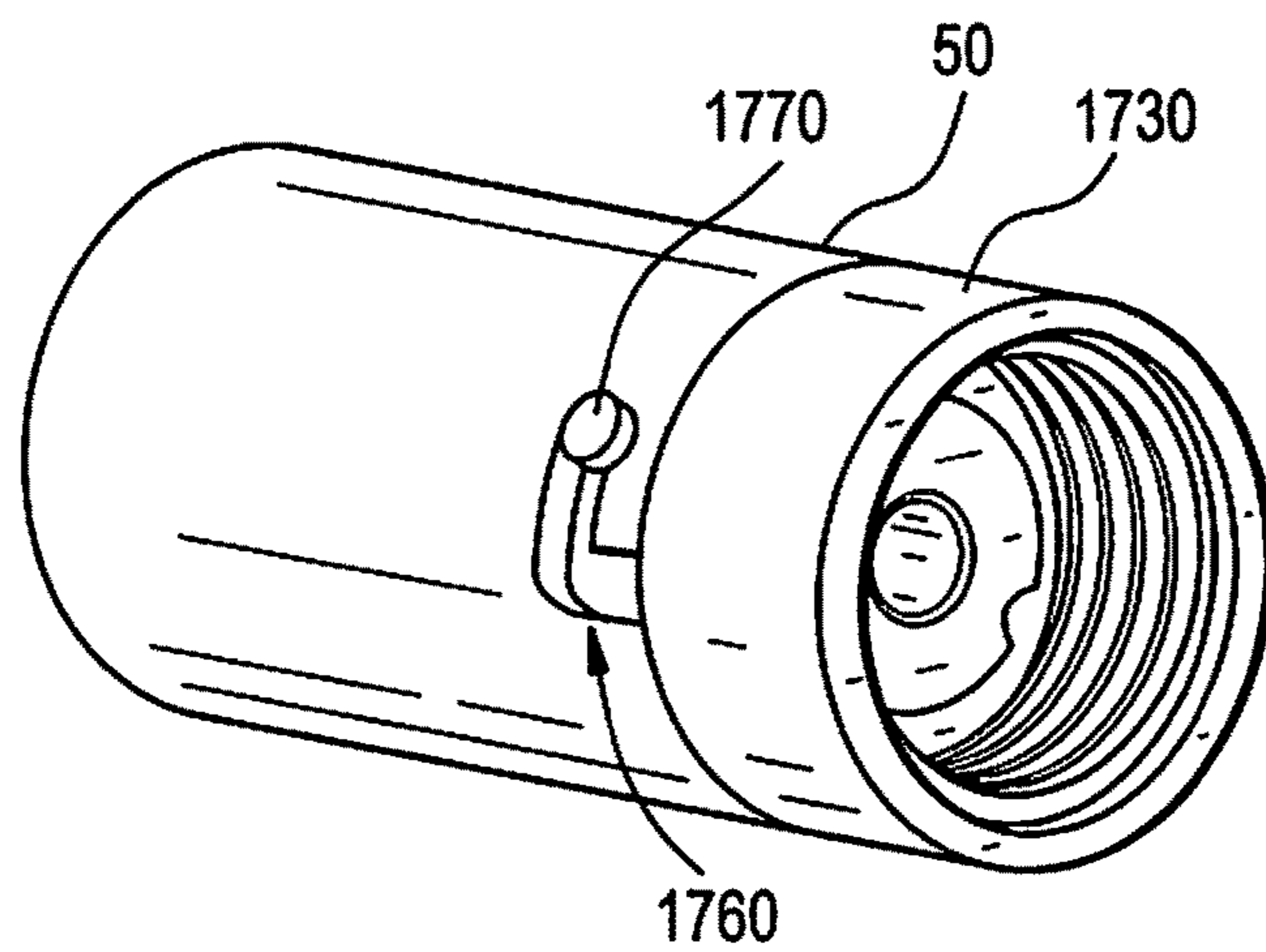


FIG. 21

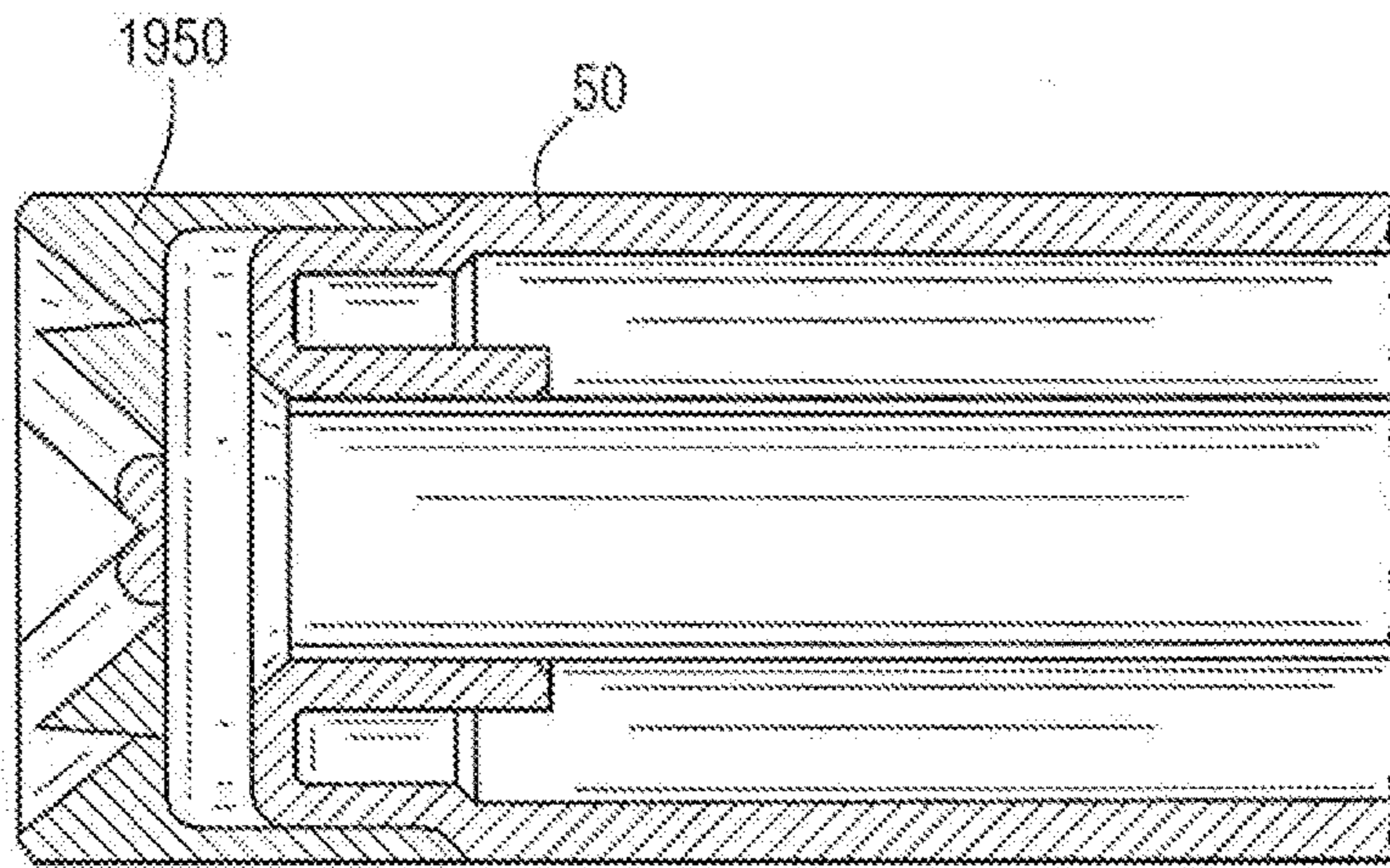
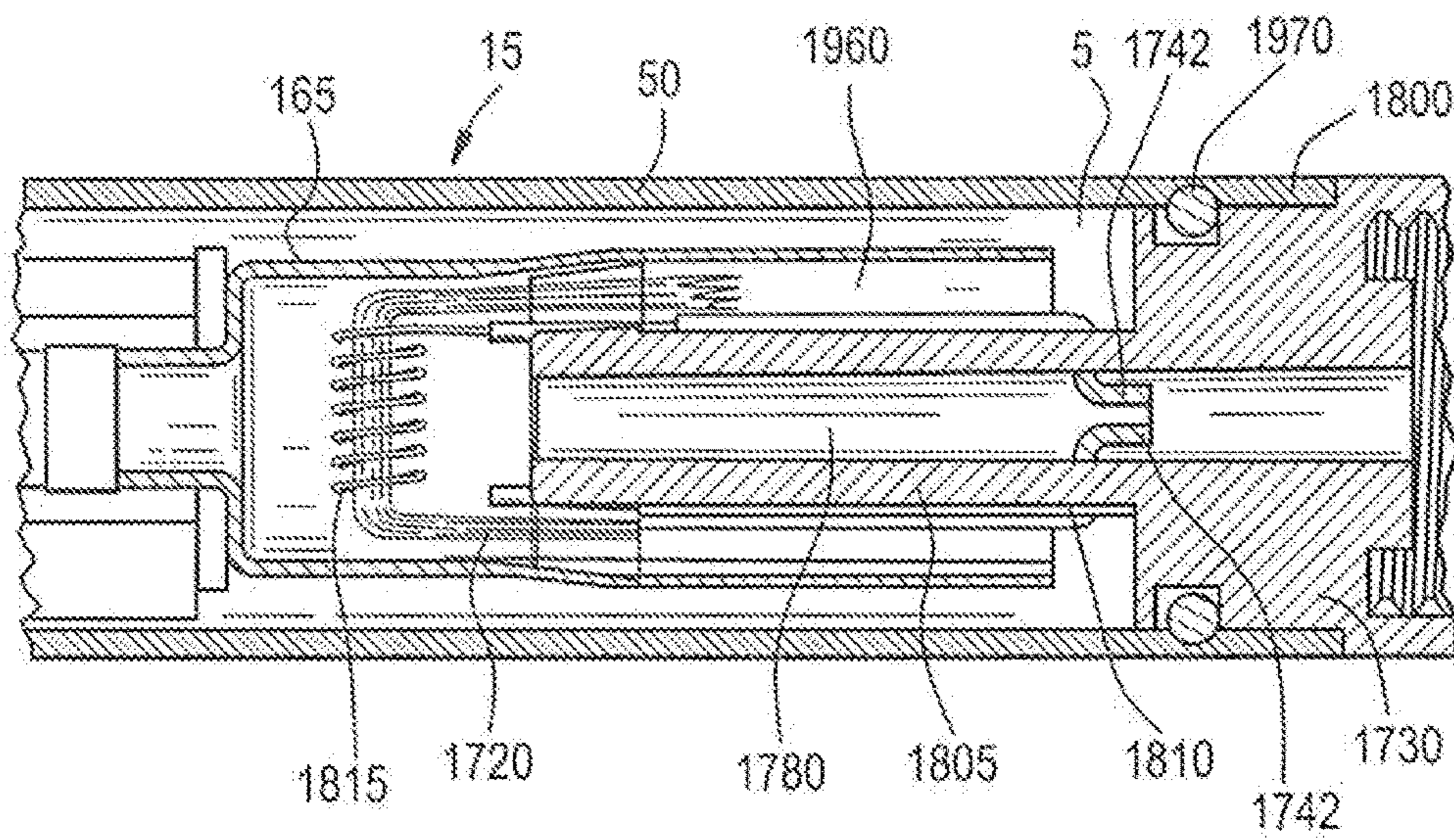


FIG. 22



CARTRIDGE AND E-VAPING DEVICE**CROSS-REFERENCE TO RELATED APPLICATION**

This application is a continuation-in-part of U.S. application Ser. No. 15/224,866, filed Aug. 1, 2016, the entire content of which is hereby incorporated by reference.

BACKGROUND**Field**

The present disclosure relates to a serpentine heater and a cartridge of an electronic vaping or e-vaping device configured to deliver a pre-vapor formulation to a vaporizer.

Description of Related Art

An e-vaping device includes a heater element which vaporizes a pre-vapor formulation to produce a "vapor."

The e-vaping device includes a power supply, such as a rechargeable battery, arranged in the device. The battery is electrically connected to the heater, such that the heater heats to a temperature sufficient to convert the pre-vapor formulation to a vapor. The vapor exits the e-vaping device through a mouthpiece including at least one outlet.

SUMMARY

At least one example embodiment relates to a cartridge of an e-vaping device.

In at least one example embodiment, the cartridge comprises a housing extending in a longitudinal direction; a reservoir in the housing, the reservoir configured to store a pre-vapor formulation; a first connector piece defining a first channel extending therethrough; a post extending through the first channel, the post defining a second channel there-through; a heater in the housing; and an absorbent material. The heater includes a first ring at a first end of the heater, a second ring at a second end of the heater, and a sinusoidal shaped member extending between the first ring and the second ring. The first ring, the sinusoidal shaped member, and the second ring are integrally formed. The second end of the tubular heater is within and connected to a portion of the post that at least partially surrounds the sinusoidal shaped member. The absorbent material at least partially surrounds the sinusoidal shaped member. The absorbent material is in fluid communication with the reservoir.

In at least one example embodiment, the cartridge further includes a sheath integrally formed with an inner tube. The sheath at least partially surrounds the absorbent material. The sheath includes an end wall. The end wall includes at least one weep hole through the end wall. The absorbent material is in fluid communication with the reservoir via the at least one weep hole.

In at least one example embodiment, the sheath is formed of an electrically conductive material. In at least one example embodiment, the first end of the heater is in contact with a portion of the sheath. In at least one example embodiment, the sheath is electrically insulated from the post.

In at least one example embodiment, the housing comprises: an end wall that is integrally formed with the housing. The end wall includes a channel therethrough. The channel is in fluid communication with an air channel extending through the inner tube.

In at least one example embodiment, the cartridge further includes a mouthpiece configured to fit over a first end of the

housing. The mouthpiece includes at least one outlet in fluid communication with the channel in the end wall.

In at least one example embodiment, the cartridge further comprises a cylindrical member extending through the first connector piece. The cylindrical member is electrically isolated from the post. The cylindrical member is formed of a conductive material, and the cylindrical member is in contact with at least a portion of the sheath.

In at least one example embodiment, the housing comprises a support tube attached to an inner wall of the housing by at least two fins. Spaces between the fins form part of the reservoir.

In at least one example embodiment, a first end of the inner tube fits with an end portion of the support tube.

In at least one example embodiment, the absorbent material comprises a hollow, cylinder of absorbent material. The absorbent material comprises glass fiber.

At least one example embodiment relates to a cartridge of an e-vaping device.

In at least one example embodiment, a cartridge of an e-vaping device comprises a housing extending in a longitudinal direction; a reservoir in the housing, the reservoir configured to store a pre-vapor formulation, an inner tube in the outer housing, the reservoir between an inner surface of the housing and an outer surface of the inner tube, the inner tube defining an air channel therein; a sheath integrally formed with the inner tube, the sheath having an end wall and a lateral wall, the sheath defining a heating chamber therein, the sheath defining an air passage through the end wall, and the air passage in fluid communication with the air channel; a gasket within the sheath, the gasket including a base portion and an elongate portion, the base portion friction fitted within the sheath and the elongate portion extending out of the sheath; a heating coil in the heating chamber; a wick in contact with the heating coil; and an absorbent material surrounding a portion of the elongate portion of the gasket.

In at least one example embodiment, the absorbent material is within the sheath, and the wick in contact with the absorbent material.

In at least one example embodiment, the gasket defines two holes through the base portion. The cartridge further comprises: a first electrical lead; and a second electrical lead. Each of the first electrical lead and the second electrical lead extend through one of the two holes through the base portion of the gasket.

In at least one example embodiment, the gasket defines at least one flow passage through the base portion and the elongate portion. The at least one channel in fluid communication with the air passage and the air channel.

In at least one example embodiment, the gasket defines at least one notch through the base portion and at least one end of the wick extends through the at least one notch.

In at least one example embodiment, the gasket is integrally molded with a connector piece.

In at least one example embodiment, the absorbent material is in fluid communication with the reservoir.

At least one example embodiment relates to a cartridge of an e-vaping device.

In at least one example embodiment, a cartridge of an e-vaping device comprises: a housing extending in a longitudinal direction; a reservoir in the housing, the reservoir configured to store a pre-vapor formulation; an inner tube in the outer housing, the reservoir between an inner surface of the housing and an outer surface of the inner tube, the inner tube defining an air channel therein; a sheath integrally formed with the inner tube, the sheath having an end wall

and a lateral wall, the sheath defining a heating chamber therein, the sheath defining an air passage through the end wall, the air passage in fluid communication with the air channel, and the sheath defining a chamber within the lateral wall; a heater in the heating chamber; and an absorbent material surrounding a portion of the elongate portion of the gasket.

In at least one example embodiment, the absorbent material is within a portion of the sheath.

In at least one example embodiment, the heater comprises: a first ring at a first end of the heater, a second ring at a second end of the heater, and a sinusoidal shaped member extending between the first ring and the second ring. The first ring, the sinusoidal shaped member, and the second ring are integrally formed.

In at least one example embodiment, the heater is a coiled heater.

BRIEF DESCRIPTION OF THE DRAWINGS

The various features and advantages of the non-limiting embodiments herein may become more apparent upon review of the detailed description in conjunction with the accompanying drawings. The accompanying drawings are merely provided for illustrative purposes and should not be interpreted to limit the scope of the claims. The accompanying drawings are not to be considered as drawn to scale unless explicitly noted. For purposes of clarity, various dimensions of the drawings may have been exaggerated.

FIG. 1A is a side view of an e-vaping device according to at least one example embodiment.

FIG. 1B is a side view of a cartridge of the e-vaping device of FIG. 1A according to at least one example embodiment.

FIG. 2 is a cross-sectional view along line II-II of a cartridge of the e-vaping device of FIG. 1A according to at least one example embodiment.

FIG. 3 is a perspective view of a heater assembly of the cartridge of FIG. 2 according to at least one example embodiment.

FIG. 4 is a second perspective view of a heater assembly of the cartridge of FIG. 2 according to at least one example embodiment.

FIG. 5 is a third perspective view of a heater assembly of the cartridge of FIG. 2 according to at least one example embodiment.

FIG. 6 is a perspective view of a heater assembly and inner tube of the cartridge of FIG. 2 according to at least one example embodiment.

FIG. 7 is an enlarged view of a heater of the cartridge of FIG. 2 according to at least one example embodiment.

FIG. 8 is an enlarged view of the heater of FIG. 7 in flat form according to at least one example embodiment.

FIG. 9 is an enlarged view of a heater in flat form according to at least one example embodiment.

FIG. 10A is an enlarged view of a portion of a heater according to at least one example embodiment.

FIG. 10B is a side view of a portion of a heater according to at least one example embodiment.

FIG. 11 is an illustration of a heater and an electrical lead according to at least one example embodiment.

FIG. 12 is an illustration of a heater and an electrical lead according to at least one example embodiment.

FIG. 13 is an illustration of a battery section of the e-vaping device of FIG. 2 according to at least one example embodiment.

FIG. 14 is a flowchart illustrating a method of forming the cartridge of FIG. 2 according to at least one example embodiment.

FIG. 15 is a flowchart illustrating a method of forming the cartridge of FIG. 2 according to at least one example embodiment.

FIG. 16 is a perspective and partial cross-sectional view of a cartridge according to at least one example embodiment.

FIG. 17 is a perspective view of a cartridge according to at least one example embodiment.

FIG. 18 is a cross-sectional view of a portion of the cartridge of FIG. 17 according to at least one example embodiment.

FIG. 19 is a perspective view of a first end of a connector according to at least one example embodiment.

FIG. 20 is a perspective view of a second end of the connector of FIG. 19 according to at least one example embodiment.

FIG. 21 is a cross-sectional view of a mouthpiece according to at least one example embodiment.

FIG. 22 is a cross-sectional view of a portion of a cartridge according to at least one example embodiment.

DETAILED DESCRIPTION OF EXAMPLE EMBODIMENTS

Some detailed example embodiments are disclosed herein. However, specific structural and functional details disclosed herein are merely representative for purposes of describing example embodiments. Example embodiments may, however, be embodied in many alternate forms and should not be construed as limited to only the example embodiments set forth herein.

Accordingly, while example embodiments are capable of various modifications and alternative forms, example embodiments thereof are shown by way of example in the drawings and will herein be described in detail. It should be understood, however, that there is no intent to limit example embodiments to the particular forms disclosed, but to the contrary, example embodiments are to cover all modifications, equivalents, and alternatives falling within the scope of example embodiments. Like numbers refer to like elements throughout the description of the figures.

It should be understood that when an element or layer is referred to as being “on,” “connected to,” “coupled to,” or “covering” another element or layer, it may be directly on, connected to, coupled to, or covering the other element or layer or intervening elements or layers may be present. In contrast, when an element is referred to as being “directly on,” “directly connected to,” or “directly coupled to” another element or layer, there are no intervening elements or layers present. Like numbers refer to like elements throughout the specification. As used herein, the term “and/or” includes any and all combinations of one or more of the associated listed items.

It should be understood that, although the terms first, second, third, etc. may be used herein to describe various elements, components, regions, layers and/or sections, these elements, components, regions, layers, and/or sections should not be limited by these terms. These terms are only used to distinguish one element, component, region, layer, or section from another region, layer, or section. Thus, a first element, component, region, layer, or section discussed below could be termed a second element, component, region, layer, or section without departing from the teachings of example embodiments.

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Spatially relative terms (e.g., “beneath,” “below,” “lower,” “above,” “upper,” and the like) may be used herein for ease of description to describe one element or feature’s relationship to another element(s) or feature(s) as illustrated in the figures. It should be understood that the spatially relative terms are intended to encompass different orientations of the device in use or operation in addition to the orientation depicted in the figures. For example, if the device in the figures is turned over, elements described as “below” or “beneath” other elements or features would then be oriented “above” the other elements or features. Thus, the term “below” may encompass both an orientation of above and below. The device may be otherwise oriented (rotated 90 degrees or at other orientations) and the spatially relative descriptors used herein interpreted accordingly.

The terminology used herein is for the purpose of describing various example embodiments only and is not intended to be limiting of example embodiments. As used herein, the singular forms “a,” “an,” and “the” are intended to include the plural forms as well, unless the context clearly indicates otherwise. It will be further understood that the terms “includes,” “including,” “comprises,” and/or “comprising,” when used in this specification, specify the presence of stated features, integers, steps, operations, elements, and/or components, but do not preclude the presence or addition of one or more other features, integers, steps, operations, elements, components, and/or groups thereof.

Example embodiments are described herein with reference to cross-sectional illustrations that are schematic illustrations of idealized embodiments and intermediate structures) of example embodiments. As such, variations from the shapes of the illustrations as a result, for example, of manufacturing techniques and/or tolerances, are to be expected. Thus, example embodiments should not be construed as limited to the shapes of regions illustrated herein but are to include deviations in shapes that result, for example, from manufacturing.

Unless otherwise defined, all terms including technical and scientific terms) used herein have the same meaning as commonly understood by one of ordinary skill in the art to which example embodiments belong. It will be further understood that terms, including those defined in commonly used dictionaries, should be interpreted as having a meaning that is consistent with their meaning in the context of the relevant art and will not be interpreted in an idealized or overly formal sense unless expressly so defined herein.

FIG. 1A is a side view of an e-vaping device according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. 1A, an e-vaping device 10 includes a cartridge (or first section) 15 and a battery section (or second section) 20, which are coupled together at a connector 30.

In at least one example embodiment, the cartridge 15 and the battery section 20 each include a housing 50, 50', respectively, extending in a longitudinal direction. The housing 50, 50' has a generally cylindrical cross-section. In at least one example embodiment, the housing 50 and/or the housing 50' may have a generally triangular or square cross-section along one or more of the cartridge 15 and the battery section 20. In at least one example embodiment, the housing 50 and/or the housing 50' may have a greater circumference or dimensions at a first end 40 of the e-vaping device 10 than at a second end 45 of the e-vaping device. The circumference and/or dimensions of the housing 50 may be the same or different than the circumference and/or dimensions of the housing 50'.

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In at least one example embodiment, the e-vaping device 10 includes an end cap 55 at the second end 45 of the e-vaping device and a mouth-end insert 60 at the first end 40 of the e-vaping device.

In at least one example embodiment, the connector 30 may be any type of connector, such as a threaded, snug-fit, detent, clamp, bayonet, and/or clasp. At least one air inlet 35 extends through a portion of the connector 30. In other example embodiments, the at least one air inlet 35 may extend through the housing 50, 50'.

In at least one example embodiment, more than two air inlets 35 may be included in the housing 50, 50'. Alternatively, a single air inlet 35 may be included in the housing 50, 50'.

In at least one example embodiment, the at least one air inlet 35 may be formed in the outer housing 50, 50' adjacent the connector 30 so as to minimize and/or reduce the chance of an adult vaper’s fingers occluding the air inlet 35 and to control the resistance-to-draw (RTD). In at least one example embodiment, the air inlet 35 may provide a substantially consistent RTD. In at least one example embodiment, the air inlet 35 may be sized and configured such that the e-vaping device 10 has a RTD in the range of from about 30 mm H₂O to about 180 mm H₂O (e.g., about 60 mm H₂O to about 150 mm H₂O or about 80 mm H₂O to about 120 mm H₂O).

In at least one example embodiment, the e-vaping device 10 may be about 80 mm to about 140 mm long and about 7 mm to about 15 mm in diameter. For example, in one example embodiment, the e-vaping device may be about 84 mm long and may have a diameter of about 7.8 mm.

In at least one example embodiment, the e-vaping device 10 may include features described in U.S. Patent Application Publication No. 2013/0192623 to Tucker et al. filed Jan. 31, 2013, the entire content of which is incorporated herein by reference thereto.

FIG. 1B is a side view of a cartridge of the e-vaping device of FIG. 1A according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. 1B, the housing 50 of the cartridge 15 may be formed of a clear and/or transparent plastic or glass. A wrapper or label 112 may circumscribe at least a portion of the housing 50. The wrapper or label 112 may have a cutout 114 therein. The cutout 114 may overlie a reservoir 5 so that a level of pre-vapor formulation stored in the reservoir 5 may be visually determined. The cutout 114 may be about 2 mm to about 10 mm wide and about 5 mm to about 20 mm in length. The size and/or shape of the cutout 114 may be adjusted depending on a circumference and/or length of the cartridge 15. In addition, the wrapper or label 112 may include markings that indicate a volume of pre-vapor formulation remaining in the reservoir 5 (discussed below).

In at least one example embodiment, the wrapper or label 112 may be a sticker and/or include at least one adhesive. The wrapper or label 112 may be laminated to protect the cartridge 15 against moisture. The wrapper or label 112 may be any color and include indicia printed thereon. The wrapper or label 112 may be smooth or rough.

FIG. 2 is a cross-sectional view along line II-II of a cartridge of the e-vaping device of FIG. 1A according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. 2, the cartridge 15 includes a first connector piece 70 at a second end of the housing 50, and the mouth-end insert 60 in a first end of the housing 50.

In at least one example embodiment, the first connector piece **70** includes a base **75** and a nose portion **80**. The base **75** is generally cylindrical in cross-section and may include a threaded section **72** on an inner surface thereof. The threaded section **72** of the first connector piece **70** may be configured to mate with a female connector piece of the battery portion **20** of the e-vaping device (not shown). The base **75** includes a flange **85** defining an orifice extending there through.

In at least one example embodiment, the first connector piece **70** is formed of metal. In other example embodiments, the first connector piece **70** may be formed of plastic. For example, the first connector piece **70** may be formed of plastic and a conductive metal insert **77** may be inserted into the first connector piece **70**. The conductive metal insert **77** may be a cathode contact. The conductive metal insert **77** may be generally ring-shaped and may include at least one electrical lead **140** extending longitudinally therefrom, such that the lead **140** extends through slot **90** in the flange **85** of the base **75**.

In at least one example embodiment, the first connector piece **70** includes a nose portion **80** at a first end of the connector body **70**. The nose portion **80** includes a first sidewall **95** defining a first channel **100** that extends longitudinally through the nose portion **80** so as to form an air passage.

In at least one example embodiment, an electrically conductive post **105** extends through the base **75**, the conductive metal insert **77**, and the first channel **100** of the nose portion **80** of the first connector piece **70**. The post **105** may have a second channel **110** extending longitudinally there through. The second channel **110** may be nested within the first channel **100**.

In at least one example embodiment, a heater **115** is supported on the post **105**, and forms a first electrical connection via the post **105**.

In at least one example embodiment, the base **75** has a larger outer diameter than an outer diameter of the nose portion **80**. The first connector piece **70** is substantially T-shaped. In other example embodiments, the first connector piece **70** may have other shapes and/or dimensions.

In at least one example embodiment, the cartridge includes a first absorbent pad **150** and an adjacent second absorbent pad **155** so as to enhance flow of pre-vapor formulation to the heater **115**. The first absorbent pad **150** surrounds the post **105** and the second absorbent pad **155** surrounds the post **105** and the heater **115**.

In other example embodiments, the cartridge **15** may include a single absorbent pad or more than two absorbent pads. The first and/or second absorbent pads **150**, **155** may completely surround the entire post **105** and/or the entire heater **115**. In another example embodiment, the first and/or second absorbent pads **150**, **155** may partially surround portions of one or more of the post **105** and/or the heater **115**. For example, the first and/or second absorbent pads **150**, **155** may include cut out portions and/or may extend partially about a circumference of the heater **115**. Additional absorbent pads may also be placed adjacent the heater **115** (not shown).

The first absorbent pad **150** is formed of a material that is more conductive to liquid than retentive so that the pre-vapor formulation in the reservoir **5** (discussed below) may flow faster towards the heater **115**. The fiber size and density of the material may be chosen to enable a desired flow rate of pre-vapor formulation. The fiber size may range from about 5 microns to about 30 microns (e.g., about 8 microns to about 15 microns). The density or pore volume of the

material may range from about 0.08 g/cc to about 0.3 g/cc (e.g., about 0.14 g/cc to about 0.19 g/cc). For example, the first absorbent pad **150** may be formed of polymer fibers, such as a combination of polypropylene (PP) and polyethylene (PE) fibers, a combination of polyethylene terephthalate (PET) and polybutylene terephthalate (PBT) fiber, and/or a combination of PET and PP fibers. For example, the first absorbent pad **150** may be formed of a combination of PET and PP fibers. The fibers may be bonded in such a way that most of the fibers are aligned along the longitudinal direction to facilitate transfer of the pre-vapor formulation.

In at least one example embodiment, the second absorbent pad **155** is a substantially retentive pad made of a material that is more retentive than conductive. The second absorbent pad **155** is closer to the heater **115** than the first absorbent pad **150**. In other example embodiments, the first absorbent pad **150** may be closer to the heater **115** than the second absorbent pad **155**.

In at least one example embodiment, the second absorbent pad **155** is formed of a material having relatively high temperature stability. The material may include fiber glass material. The thickness of the second absorbent pad **155** may play a role in determining the thermal mass (amount of liquid that needs to be heated to form a vapor). The thickness of the second absorbent pad **155** may range from about 0.3 mm to about 2.0 mm (e.g., about 0.6 mm to about 0.8 mm). The first and second absorbent pads **150**, **155** may have a same or different thickness. A length of the first and/or second absorbent pad **150**, **155** may range from about 2 mm to about 10 mm (e.g., about 3 mm to about 9 mm or about 4 mm to about 8 mm). The length of the first absorbent pad **150** may be the same or different than the second absorbent pad **155**.

The first absorbent pad **150** is at least partially retentive so as to substantially prevent and/or reduce leakage of pre-vapor formulation, while allowing the pre-vapor formulation to travel to the second absorbent pad **155** and the heater **115**.

In at least one example embodiment, the material used to form the first absorbent pad **150** is not heat resistant since the first absorbent pad **150** is not in direct contact with the heater **115**. In other example embodiments, the material used to form the first absorbent pad **150** is heat resistant.

In at least one example embodiment, the cartridge **10** also includes a sheath **165**. The sheath **165** surrounds the first and second absorbent pads **150**, **155**. In other example embodiments, the sheath **165** may only surround a portion of one or more of the first and second absorbent pads **150**, **155**.

In at least one example embodiment, the sheath **165** includes an end wall **170** having an outlet **180** therein. The outlet **180** is in fluid communication with the first channel **100** of the post **105**. The sheath **165** may be generally cup-shaped and may be sized and configured to fit over the first and second absorbent pads **150**, **155** and the heater **115**.

In at least one example embodiment, the sheath **165** is formed of a conductive metal. For example, the sheath **165** may be formed of stainless steel. The sheath **165** isolates the heater **115** and the first and second absorbent pads **150**, **155** from the reservoir **5** (discussed in more detail below). Any combination of absorbent pads and sheath with different conductivity and/or retention and/or thermal and/or other characteristics may be used based on a desired level of vapor mass, temperature, leakage, immunity, and the like.

In at least one example embodiment, the cartridge **10** also includes an inner tube **190** having an inner tube air passage **200** there through. The inner tube air passage **200** is in fluid communication with the outlet **180** in the sheath **165** and the second channel **110** in the post **105**. The inner tube **190** may

be formed of a metal or polymer. In at least one example embodiment, the inner tube **190** is formed of stainless steel.

In at least one example embodiment, the housing **50** abuts the base **75** of the first connector piece **70**. The housing **50** substantially surrounds the sheath **165** and the inner tube **190**.

In at least one example embodiment, the housing **50** is substantially clear. The housing **50** may be made of glass or clear plastic so as to enable an adult vaper to visually determine a level of pre-vapor formulation in the reservoir **5**.

In at least one example embodiment, a gasket **12** is between the inner tube **190** and the housing **50**. An outer perimeter of the gasket **12** provides a seal with an interior surface of the housing **50**.

In at least one example embodiment, the reservoir **5** is established between the inner tube **190**, the outer housing **50**, the gasket **12**, and the base **75** of the first connector piece **70**. The reservoir **5** may be filled with pre-vapor formulation via injection through the gasket **12**, which may act as a septum.

In at least one example embodiment, the reservoir **5** is sized and configured to hold enough pre-vapor formulation such that the e-vaping device **10** may be configured for vaping for at least about 200 seconds. Moreover, the e-vaping device **10** may be configured to allow each puff to last about 10 seconds or less.

In at least one example embodiment, the pre-vapor formulation may be a material or combination of materials that may be transformed into a vapor. For example, the pre-vapor formulation may be a liquid, solid and gel formulation including, but not limited to, water, beads, solvents, active ingredients, ethanol, plant extracts, natural or artificial flavors, and/or vapor formers such as glycerin and propylene glycol.

In at least one example embodiment, the first section **70** may be replaceable. In other words, once the pre-vapor formulation of the cartridge **15** is depleted, the cartridge **15** may be replaced.

In at least one example embodiment, the reservoir **5** may also include a storage medium (not shown) configured to store the pre-vapor formulation therein. The storage medium may include a winding of cotton gauze or other fibrous material about the inner tube **190**.

The storage medium may be a fibrous material including at least one of cotton, polyethylene, polyester, rayon and combinations thereof. The fibers may have a diameter ranging in size from about 6 microns to about 15 microns (e.g., about 8 microns to about 12 microns or about 9 microns to about 11 microns). The storage medium may be a sintered, porous or foamed material. Also, the fibers may be sized to be irrespirable and may have a cross-section which has a Y-shape, cross shape, clover shape or any other suitable shape. In an alternative example embodiment, the reservoir **5** may include a filled tank lacking any storage medium and containing only pre-vapor formulation.

In at least one example embodiment, the mouth-end insert **60** is inserted in an end of the housing **50**. The mouth-end insert **60** includes at least one outlet **65** extending through an end surface of the mouth-end insert. The outlet **65** is in fluid communication with the inner tube air passage **200** extending through the inner tube **190**.

In at least one example embodiment, as shown in FIG. 2, the mouth-end insert **60** includes at least two outlets **65**, which may be located off-axis from the longitudinal axis of the e-vaping device **10**. The outlets **65** are angled outwardly in relation to the longitudinal axis of the e-vaping device **10**.

The outlets **65** may be substantially uniformly distributed about the perimeter of the mouth-end insert **60** so as to substantially uniformly distribute vapor.

During vaping, pre-vapor formulation may be transferred from the reservoir **5** and/or storage medium (not shown) to the proximity of the heater **115** via capillary action of the first and second absorbent pads **150**, **155**. In at least one example embodiment, as shown in FIG. 2, the heater **115** vaporizes pre-vapor formulation, which may be drawn from the reservoir **5** by the first and second absorbent pads **150**, **155**.

FIG. 3 is a perspective view of a heater assembly of the cartridge of FIG. 2 according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. 3, the heater assembly includes the first connector piece **70**, the post **105**, and the heater **115** as shown in FIG. 2. In addition, the first connector piece **70** may include at least one external channel **120** extending along an outer surface of the first sidewall **95**. The at least one external channel **120** extends substantially in the longitudinal direction. The at least one external channel **120** is sized and configured to allow a pre-vapor formulation to travel from the reservoir **5** underneath the sheath **165** and to the first and second absorbent pads **150**, **155** and the heater **115**. In other example embodiments, the at least one external channel **120** may have a tortuous form.

FIG. 4 is a second perspective view of a heater assembly of the cartridge of FIG. 2 according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. 4, the heater assembly is the same as in FIG. 3, but is shown with the second heater electrical lead **130** extending from the heater **115** and through an opening in the first absorbent pad **150**.

FIG. 5 is a third perspective view of a heater assembly of the cartridge of FIG. 2 according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. 5, the heater assembly is the same as in FIGS. 3 and 4, but is shown with the sheath **165** contacting the lead **140** and the second heater electrical lead **130** so as to form a second electrical contact with the heater. As will be recalled, the first heater electrical lead **125** is in contact with the post **105** to form the first electrical contact.

FIG. 6 is a perspective view of a heater assembly and inner tube of the cartridge of FIG. 2 according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. 6, the heater assembly is the same as in FIGS. 3-5, but is shown joined with the inner tube **190**. As shown in FIG. 6, the inner tube **190** includes an inner tube base portion **192** that substantially surrounds the sheath **165** at a first end thereof. The inner tube base portion **192** may be sized and configured, such that the sheath **165** is held within the inner tube base portion **192** by friction fit. In other example embodiments, the inner tube base portion **192** may fit over the sheath **165** with threads, by snap-fit, or any other suitable connection.

In an example embodiment, the inner tube **190** has an inner diameter ranging from about 2 mm to about 6 mm (e.g., about 4 mm). The inner tube **190** defines the inner tube air passage **200** there through. The inner tube air passage **200** is in fluid communication with the second channel **110** through the post **105**.

FIG. 7 is an enlarged view of a heater of the cartridge of FIG. 2 according to at least one example embodiment.

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In at least one example embodiment, as shown in FIG. 7, the heater is the same as in FIGS. 2-3, but is shown in greater detail. As shown, the heater **115** includes a plurality of lobes **202**. The heater **115** may include a first set **205** of lobes **202** and a second set **210** of lobes **202**, such that the heater **115** has a generally serpentine or sinuous shape along a circumference thereof. The heater **115** may be formed by stamping a flat metal sheet, such as a sheet of stainless steel to form the generally serpentine or sinuous shape. The lobes **202** may be generally flat. The heater **115** is curled and/or rolled to form a generally tubular and elliptical (e.g., circular) heater. Once curled and rolled, the heater **115** defines a first air passage **300** extending longitudinally through the heater **115**. The first set **205** of lobes **202** may be closer to the first end **40** of the cartridge **15** than the second set **210** of lobes **202**. Thus, the heater **115** may extend substantially parallel to the longitudinal axis of the cartridge **15** and/or e-vaping device **10**. The first air passage **300** is in fluid communication with the second channel **110** and the inner tube air passage **200**. In at least one example embodiment, the heater **115** may be formed by laser cutting, photochemical etching, electrochemical milling, etc. The heater **115** may be formed of a nickel-chromium alloy or a nickel-chromium-iron alloy.

In at least one example embodiment, the heater **115** may be formed of any suitable electrically resistive materials. Examples of suitable electrically resistive materials may include, but not limited to, titanium, zirconium, tantalum and metals from the platinum group. Examples of suitable metal alloys include, but not limited to, stainless steel, nickel, cobalt, chromium, aluminum-titanium-zirconium, hafnium, niobium, molybdenum, tantalum, tungsten, tin, gallium, manganese and iron-containing alloys, and super-alloys based on nickel, iron, cobalt, stainless steel. For example, the heater **115** may be formed of nickel aluminide, a material with a layer of alumina on the surface, iron aluminide and other composite materials, the electrically resistive material may optionally be embedded in, encapsulated or coated with an insulating material or vice-versa, depending on the kinetics of energy transfer and the external physicochemical properties required. The heater **115** may have burrs completely removed via electrochemical etching. The heater **115** may include at least one material selected from the group consisting of stainless steel, copper, copper alloys, nickel-chromium alloys, super alloys and combinations thereof. In at least one example embodiment, the heater **115** may be formed of nickel-chromium alloys or iron-chromium alloys. In another example embodiment, the heater **115** may be a ceramic heater having an electrically resistive layer on an outside surface thereof. The heater **115** may have a resistance of about 3.1 ohms to about 3.5 ohms (e.g., about 3.2 ohms to about 3.4 ohms).

When activated, the heater **115** heats a portion of the second absorbent pad **155** surrounding the heater **115** for less than about 15 seconds. Thus, the power cycle (or maximum puff length) may range in period from about 2 seconds to about 12 seconds (e.g., about 3 seconds to about 10 seconds, about 4 seconds to about 8 seconds or about 5 seconds to about 7 seconds).

Because the heater **115** extends parallel to the longitudinal direction and is generally serpentine in shape, a greater amount of surface area of the second absorbent pad **155** is covered as compared to a wire or wire coil heater.

Moreover, since the first air passage **300** extending through the heater **115** is parallel to longitudinal direction and the second absorbent pad **155** substantially surrounds the heater **115**, the vapor flows to the first air passage **300** as

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it is formed without any portion of the cartridge **15** blocking flow of the vapor from the heater **115**.

FIG. **8** is an enlarged view of the heater of FIG. **7** in flat form according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. **7**, the heater **115** is the same as in FIGS. **2**, **3**, and **7**, but is shown with the first electrical lead **125** and a second electrical lead **130**. The first electrical lead **125** and the second electrical lead **130** may be wider than portions of the heater **115** forming the lobes **202**. For example, the first electrical lead **125** and the second electrical lead **130** may have a width ranging from about 0.25 mm to about 1.0 mm (e.g., about 0.3 mm to about 0.9 mm or about 0.4 mm to about 0.7 mm). For example, the width of the leads **125**, **130** may be about 0.5 mm.

In addition, the heater **115** is designed to control the resistance distribution across the heater's geometry. A width **D2** of the lobes **202** is wider than a width **D1** of vertical portions of the heater **115**. As a result, the electrical resistance of the lobes **202** is lower, such that the lobes **202** get less hot than vertical portions of the heater **115** thereby allowing for most of the heat to be across the vertical portions of the heater **115**. The width **D1** may range from about 0.1 mm to about 0.3 mm (e.g., about 0.15 mm to about 0.25 mm). For example, the width **D1** may be about 0.13 mm. A width **D3** of each lobe **202** may range from about 0.2 mm to about 0.4 mm.

FIG. **9** is an enlarged view of a heater in flat form according to at least one example embodiment.

In at least one example embodiment, the heater **115** may have other designs that also allow for controlled resistance distribution. For example, in at least one example embodiment, the heater **115** may include lobes and transverse portions forming arrow shapes in lieu of a sinusoidal shape. In at least one example embodiment, a central portion **132** between opposing lobes may form an apex that is not in line with the lobes. The apex may be at an angle of about 10 degrees to about 90 degrees from each of the opposing lobes. For example, the lobes and the central portion **143** may form a generally triangular shape. A distance between adjacent central portions **132** and/or lobes may be substantially uniform. In other example embodiments, the distance between the adjacent central portions **132** and/or lobes may vary along the heater **115**. The distance between adjacent central portions **132** and lobes may range from about 0.05 mm to about 1.0 mm (e.g., about 0.1 mm to about 0.9 mm, about 0.2 mm to about 0.8 mm, about 0.7 mm to about 0.6 mm, or about 0.4 mm to about 0.5 mm). For example, the distance between adjacent central portions may be about 0.09 mm.

FIG. **10A** is an enlarged view of a portion of a heater according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. **10A**, the heater **115** is the same as in FIGS. **2**, **3**, **7**, and **8**, but also includes tabs **215**.

FIG. **10B** is a side view of a portion of a heater according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. **10B**, the tabs **215** may be folded outwardly from the first air passage **300**. The tabs **215** may create a tighter contact between the heater **115** and the second absorbent pad **155**, and/or may increase a contact surface area between the heater **115** and the second absorbent pad **155**.

FIG. **11** is an illustration of a heater and an electrical lead according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. **11**, the heater **115** is the same as in FIGS. **2**, **3**, **7**, and **8**, but may

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have the second electrical lead **130** bent inwardly within the first air passage **300**. The second electrical lead **130** may direct the air flow through the first air passage **300** and affect the RTD in a desired manner. In at least one example embodiment, the second electrical lead **130** may be cut in half (not shown), with one half extending inwardly as shown in FIG. **11**, and with each half contacting a separate portion of the sheath **165** to establish electrical communication between the heater **115** and the power supply **225** (shown in FIG. **13**).

FIG. **12** is an illustration of a heater and an electrical lead according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. **12**, the second electrical lead **130** may include an end surface **160** defining a plurality of orifices **167** therein. The orifices **167** may alter the air flow through the cartridge **15** and may adjust the RTD of the e-vaping device **10**.

FIG. **13** is an illustration of a battery section of the e-vaping device of FIG. **2** according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. **13**, the second section **20** includes a second connector piece **220**, a sensor **230** responsive to air drawn into the second section **20** via an air inlet port **35** (shown in FIG. **1**), the power supply **225**, a control circuit **235**, a light **240**, and the end cap **55**. The second connector piece **220** is configured to connect with the first connector piece **70** of the cartridge **15** (shown in FIG. **2**).

In at least one example embodiment, the connector **220** may include a male threaded section **222** and an inner contact **224**, which contact the conductive metal insert **77** and the post **105**, respectively, of the cartridge **15**. The male threaded section **222** is insulated from the inner contact **224**. Thus, the male threaded section **222** contacts the conductive metal insert **77**, which includes the leads **140** that contact the sheath **165**, and the sheath **165** contacts the second electrical lead **130** of the heater **115**. The inner contact **224** contacts the post **105**, which contacts the first electrical lead **125** of the heater **115**.

In at least one example embodiment, a first terminal of the power supply **225** connects to the post **105** and a second terminal of the power supply **225** connects to the control circuit **235** via lead **330**. The control circuit **235** connects to the sensor **230** and to the conductive metal insert **77** via lead wire **320**.

In at least one example embodiment, the power supply **225** may include a battery arranged in the e-vaping device **10**. The power supply **225** may include a Lithium-ion battery or one of its variants, for example a Lithium-ion polymer battery. Alternatively, the power supply **225** may include a nickel-metal hydride battery, a nickel cadmium battery, a lithium-manganese battery, a lithium-cobalt battery or a fuel cell. The e-vaping device **10** may be vapable by an adult vaper until the energy in the power supply **225** is depleted or in the case of lithium polymer battery, a minimum voltage cut-off level is achieved.

In at least one example embodiment, the power supply **225** may include a battery and circuitry configured to shape a waveform of power applied to the heater so that the output of the battery cell may be attenuated, "chopped," etc. before the power is applied to the heater.

In at least one example embodiment, the power supply **225** may be rechargeable. The second section **20** may include circuitry configured to allow the battery to be chargeable by an external charging device. To recharge the e-vaping device **10**, an USB charger or other suitable charger assembly may be used.

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In at least one example embodiment, the sensor **230** is configured to generate an output indicative of a magnitude and direction of airflow in the e-vaping device **10**. The control circuit **235** receives the output of the sensor **230**, and determines if (1) the direction of the airflow indicates a draw on the mouth-end insert **60** (versus blowing) and (2) the magnitude of the draw exceeds a threshold level. If these conditions are met, the control circuit **235** electrically connects the power supply **225** to the heater **115**. In an alternative embodiment, the sensor **230** may indicate a pressure drop, and the control circuit **235** activates the heater **115** in response thereto.

In at least one example embodiment, the control circuit **235** may also include a light **240** configured to glow when the heater **115** is activated and/or the battery is being recharged. The heater activation light **240** may include an LED. Moreover, the heater activation light **240** may be arranged to be visible to an adult vaper during vaping. In addition, the heater activation light **240** may be utilized for e-vaping system diagnostics or to indicate that recharging is in progress. The heater activation light **240** may also be configured such that the adult vaper may activate and/or deactivate the heater activation light **240** for privacy. The heater activation light **240** may be on a second end **45** of the e-vaping device **10** or along a side of the housing **50**, **50'**.

In at least one example embodiment, the control circuit **235** may include a maximum, time-period limiter. In another example embodiment, the control circuit **235** may include a manually operable switch for an adult vaper to activate the e-vaping device **10**. The time-period of the electric current supply to the heater **115** may be pre-set depending on the amount of pre-vapor formulation desired to be vaporized. In yet another example embodiment, the control circuit **235** may supply power to the heater **115** as long heater activation conditions are met.

In at least one example embodiment, upon completing the connection between the cartridge **15** and the second section **20**, the power supply **225** may be electrically connectable with the heater **115** of the cartridge **15**. Air is drawn primarily into the cartridge **15** through the at least one air inlet **35**, which may be located along the housing **50**, **50'** or at the connector **30** (as shown in FIG. **1**).

FIG. **14** is a flowchart illustrating a method of forming the cartridge of FIG. **2** according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. **14**, a method of manufacturing the cartridge of FIG. **2** includes inserting **1000** a post through an orifice in a connector body, attaching **1010** a first lead of a heater to the post, curling **1020** the heater to form a substantially tubular heater, placing **1030** an absorbent material around the heater, placing **1040** a sheath around the absorbent material, and attaching **1050** a second lead of the heater to the sheath. The attaching **1010** may include welding and/or crimping of the first lead to the post. The attaching **1050** may include welding and/or crimping of the second lead to the sheath. In another example embodiment, the curling step **1020** may precede the attaching step **1010**.

In at least one example embodiment, the method may include positioning **1060** an inner tube at an opening in the sheath, and positioning **1070** an outer housing around the sheath and the inner tube. The positioning may include friction fitting the housing with the first connector piece.

In at least one example embodiment, the method may also include inserting **1080** a gasket between the inner tube and

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the outer tube so as to establish a reservoir between the first connector piece, the inner tube, the outer housing, and the gasket.

In at least one example embodiment, the method may also include inserting **1090** a mouth-end insert in a first end of the outer housing.

FIG. **15** is a flowchart illustrating a method of forming the cartridge of FIG. **2** according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. **15**, the method may include inserting **2000** a cathode contact (conductive metal insert **77**) into a connector piece **70**, applying **2010** a sealant to leads of the conductive metal insert **77**, inserting **2020** the post **105** into the first connector piece **70**, sliding **2030** the first absorbent pads **150** over a first end of the post **105**, attaching the first electrical lead **125** of the heater **115** to the post **105**, and rolling and/or curling the heater **115** to form a substantially tubular heater **115**. Opposing portions of the tubular heater **115** may be spaced about 0.05 mm to about 0.25 mm apart (e.g., about 0.1 mm to about 0.2 mm). For example, opposing portions of the tubular heater **115** may be about 0.17 mm apart. In other example embodiments, the opposing portions may be in direct physical contact.

In at least one example embodiment, the method may also include wrapping **2060** a second absorbent pad **150** around the heater **115**, sliding **2080** a sheath **165** over the first and second absorbent pads **150**, **155**, attaching the second electrical lead **130** of the heater **115** to the sheath **165**, and visually confirming **2090** the outlet **160** is open.

In at least one example embodiment, the method may also include press-fitting **2400** the inner tube **190** onto the sheath **165**, connecting **2110** the leads **140** of the conductive metal insert **77** to the sheath **165**, and vacuuming **2120** any debris from the subassembly. The connecting **2110** may include spot welding.

In at least one example embodiment, the method may also include checking **2130** resistance of the subassembly, connecting **2140** the barrel to the connector base, and checking **2150** resistance of the assembly. The connecting **2140** may include ultrasonic welding.

In at least one example embodiment, the method may also include filling **2160** the reservoir **5** with the pre-vapor formulation, inserting **2170** the gasket **12** into the housing **50**, inserting **2180** the mouth-end insert **60** into the housing **50**, and testing **2190** the cartridge **15** on a puffing device.

In at least one example embodiment, the method may further include applying **2200** a sticker to an outside surface of the housing placing **2210** the cartridge **15** into a package, and/or indicating **2220** an expiration date and/or flavor of the pre-vapor formulation on the package. The package may be a foil pouch. The foil pouch may be heat sealed and/or substantially air tight. The indicating **2220** may include laser etching or printing.

In at least one example embodiment, the cartridge described herein allows for automated manufacture because of the reduced number of parts, lack of heater coil to be wound, and the use of snap-fit and pressure fit parts.

In at least one example embodiment, the cartridge may be made with molded and/or plastic connectors. In at least one example embodiment, any metal parts may be made by machining, deep drawing, etc.

In at least one example embodiment, the heater may be moved closer to the channels extending under the sheath so as to shorten a distance the pre-vapor formulation must travel to reach the heater. In at least one example embodiment, the absorbent material thickness may be reduced to

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reduce thermal mass. In at least one example embodiment, circulation may be increased and/or improved by positioning a fin or disperser structure in a center of the air channel, such that high velocity air is forced to flow near a wall of the air channel and/or pass over the heater.

FIG. **16** is a perspective and partial cross-sectional view of a cartridge according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. **16**, the cartridge **15** is the same as in FIGS. **2-6**, except that sheath **165** is integrally formed with the inner tube **190**, the cartridge **15** includes a support tube **1650**, the heater **115'** is formed from a tube, and the first and second absorbent pads **150**, **155** are concentrically arranged. In addition, instead of the conductive metal insert a cylindrical member **1670** extends through the first connector piece **70** and contacts the sheath **165** as further described below.

As shown in FIG. **16**, the heater **115'** includes a first end ring **1600** and a second end ring **1610**. A sinusoidal shaped member **1620** extends between the first end ring **1600** and the second end ring **1610**. The heater **115'** may be formed by etching and/or laser cutting the sinusoidal shaped member **1620** into a tube, and the sinusoidal shaped member **1620** may have a substantially same shape as the heater **115** of FIG. **2**.

In at least one example embodiment, the sheath **165** is integrally formed with the inner tube **190**. The sheath **165** has an end wall **1640** defining at least one weep hole **1630** therein. Thus, the example embodiment of FIG. **16** does not include the external channels **120** through which the pre-vapor formulation flows, as shown in FIGS. **3-4**. Instead, the pre-vapor formulation flows from the reservoir **5**, through the at least one weep hole **1630** and to the first and second absorbent pads **150**, **155**. The size and number of weep holes **1630** may be adjusted to substantially control flow of the pre-vapor formulation therethrough.

In at least one example embodiment, as shown in FIG. **16**, the support tube **1650** is concentrically arranged in the housing **50**. Fins **1660** maintain the support tube **1650** in position within the housing **50**. In at least one example embodiment, the support tube **1650** and the fins **1660** are integrally formed with the housing **50**. In other example embodiment, the support tube **1650** and the fins **1660** are inserted into the housing **50**. The support tube **1650** has an end that abuts and/or mates with a first end of the inner tube **190**.

In at least one example embodiment, the first ring **1600** of the heater **115'** contacts and/or engages a portion of the integrally formed inner tube **190** and sheath **165**. The second ring **1610** contacts and/or is inserted into a first end of the conductive post **105** that extends through the first connector piece **70**. The cylindrical member **1670** also extends through the first connector piece **70** and is electrically insulated from the conductive post by a portion of the connector piece **70**. The cylindrical member **1670** contacts the sheath **165**. At least a portion of the cylindrical member **1670** and at least a portion of the sheath **165** surround the absorbent members **150**, **155**. Thus, a first end of the heater **115'** is electrically connected to the battery section **20** via the sheath **165** and the cylindrical member **1670**, while a second end of the heater **115'** is electrically connected to the battery section **20** via the conductive post **105**.

FIG. **17** is a perspective view of a cartridge according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. **17**, the cartridge **15** is the same as the cartridge of FIG. **2** except that the cartridge **15** includes a wick **1720** extending through outlets **1725** defined in a sidewall of the sheath **165**, and the

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cartridge **15** includes a connector **1730** including a base portion **1800** and an extension **1810** that abuts and/or is connected to the sheath **165**.

In at least one example embodiment, as shown in FIG. **17**, the inner tube **190** can include a plurality of fins **1700** that may be integrally formed with the inner tube **190**. The plurality of fins **1700** maintain the inner tube **190** in position within the housing **50** of the cartridge **15**. In other example embodiments, the fins **1700**, and optionally the inner tube **190**, may be integrally formed with the housing **50**.

In at least one example embodiment, a gasket **1775** is arranged between a portion of the sheath **165**. The gasket **1775** may create a pressure point about the sheath **165**, which holds the sheath **165** in place against and/or within the inner tube **190** and/or provides a seal between the sheath **165** and the inner tube **190** if the sheath **165** and the inner tube **190** are not integrally formed. The gasket **1775** may be a silicone disk or ring.

In at least one example embodiment, as shown in FIG. **17**, the sheath **165** abuts and/or extends around a gasket portion **1830** of the extension **1810** of the connector piece **1730**. The gasket portion **1830** has a generally cylindrical cross-section, and the connector piece **1730** has a barbell or "I" shape. The gasket portion **1830** has a larger diameter than a central portion of the extension **1810**. The gasket portion **1830** seals a second end of the sheath **165**, such that the pre-vapor formulation cannot enter an interior area of the sheath **165**.

In at least one example embodiment, the connector piece **1730** also includes a base **1800** having internal threads. In other example embodiments, the base **1800** may have external threads. The base **1800** and the extension **1810** define an air channel **1780** therethrough. The air channel **1780** is in fluid communication with the air channel in the inner tube **190** via the sheath **165**.

In at least one example embodiment, the base **1800** further defines channels **1750** through which electrical leads extend. The channels **1750** extend through the gasket portion **1830**. The electrical leads **1742**, **1742'** are attached to ends of the heater and to the battery section **20** to form the electrical connection between the heater and the power supply. As shown in FIG. **17**, the electrical leads **1742**, **1742'** extend along an outer surface of the extension **1810** and through the channels **1750** in the gasket portion **1830** and the base **1800**. In other example embodiments, electrical leads may be in-molded through the connector piece **1730** as set forth in U.S. patent application Ser. No. 15/349,377 to Patil et al., filed Nov. 11, 2016, the entire content of which is incorporated herein by reference thereto.

In at least one example embodiment, as shown in FIG. **17**, the housing **50** includes a groove **1740** therein that is configured to secure a slide **1770** therein. The groove **1740** may be generally "L" shaped, though the groove **1740** may be any other suitable shape. The slide **1770** is formed on an outer surface of the connector piece **1730**. The slide **1770** and the groove **1740** cooperate to secure the connector piece **1730** to the housing **50**. The slide **1770** is aligned with an opening in the groove **1740** and then the connector piece **1730** is rotated to lock the slide **1770** within the groove **1740**.

FIG. **18** is a cross-sectional, enlarged view of a portion of the cartridge of FIG. **17** according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. **18**, the heater **1815** may be a heater coil that surrounds a portion of the wick **1720**. Ends of the wick **1720** extend into the reservoir **5** via the outlets **1725** defined in a sidewall of the sheath **165**. The extension **1810** of the connector piece

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includes the gasket portion **1830** that has an outer surface **1835** and a generally frustoconical shape. The outer surface **1835** of the gasket portion **1830** is sized and configured to snugly fit within a portion of the sheath **165** so as to substantially seal an end of the sheath **165** and/or substantially prevent the pre-vapor formulation from entering the sheath **165** except via the wick **1720**.

The heater **1815** and wick **1720** may be formed as set forth in U.S. Patent Application Publication No. 2013/0192623 to Tucker et al. filed Jan. 31, 2013 and/or features set forth in U.S. patent application Ser. No. 15/135,930 to Holtz et al. filed Apr. 22, 2016, the entire contents of each of which are incorporated herein by reference thereto. In other example embodiments, the e-vaping device may include the features set forth in U.S. patent application Ser. No. 15/135,923 filed Apr. 22, 2016, and/or U.S. Pat. No. 9,289,014 issued Mar. 22, 2016, the entire contents of each of which is incorporated herein by this reference thereto.

FIG. **19** is a perspective view of a first end of a connector according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. **19**, the connector piece **1730** includes the base **1800** and the extension **1810**. The extension **1810** includes the gasket portion **1830** and a central portion **1805**. The channel **1750** extends through the base **1800**, the extension **1810**, and the gasket portion **1830** of the connector piece **1730**. The connector piece **1730** further includes notches **1900** in the gasket portion **1830** that are sized and configured to hold ends of the wick **1720**. The notches **1900** may be on opposing sides of the connector piece **1730**.

FIG. **20** is a perspective view of a second end of the connector of FIG. **19** according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. **20**, the connector piece **1730** has an outer surface having a same outer diameter as the housing **50**. The connector piece **1730** may be molded of any suitable polymer.

FIG. **21** is a cross-sectional view of a mouthpiece according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. **21**, the cartridge **15** may be the same as in FIG. **2**, but instead of a mouth-end insert, the cartridge includes a mouthpiece **1950** that surrounds an end portion of the housing **50**. The housing **50** and an inner surface of the mouthpiece **1950** may be sized and configured to form a friction fit therebetween. In other example embodiments, the housing **50** and the mouthpiece **1950** may be adhered or fastened together via threads, glue, and/or other suitable fasteners.

FIG. **22** is a cross-sectional view of a portion of a cartridge according to at least one example embodiment.

In at least one example embodiment, as shown in FIG. **22**, the cartridge **15** is the same as in FIG. **17**, except that the sheath **165** extends over the central portion **1805** of the extension **1810** of the connector piece **1730** and an absorbent material **1960** is positioned between an inner wall of the sheath **165** and an outer surface of the connector piece **1730**. In addition, the electrical leads **1742**, **1742'** extend through a sidewall of the central portion **1805** of the connector piece **1730**, into the air channel **1780**, and to the battery section (not shown).

In at least one example embodiment, the absorbent material **1960** is a high density absorbent material that is configured to transfer the pre-vapor formulation from the reservoir **5** to the wick **1720**.

In at least one example embodiment, the cartridge **15** also includes a seal **1970**, such as an O-ring, between an inner

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surface of the housing **50** and an outer surface of the base **1800** of the connector piece **1730**.

While a number of example embodiments have been disclosed herein, it should be understood that other variations may be possible. Such variations are not to be regarded as a departure from the spirit and scope of the present disclosure, and all such modifications as would be obvious to one skilled in the art are intended to be included within the scope of the following claims.

We claim:

1. A cartridge of an e-vaping device, the cartridge comprising:

a housing extending in a longitudinal direction;
a reservoir in the housing, the reservoir configured to store a pre-vapor formulation;

a first connector piece defining a first channel extending therethrough;

a post extending through the first channel, the post defining a second channel therethrough;

a heater in the housing, the heater including,

a first ring at a first end of the heater,

a second ring at a second end of the heater, and

a sinusoidal shaped member extending between the first ring and the second ring, the first ring, the sinusoidal shaped member, and the second ring being integrally formed, the second end of the heater within and connected to a portion of the post; and

an absorbent material at least partially surrounding the sinusoidal shaped member, the absorbent material in fluid communication with the reservoir.

2. The cartridge of claim **1**, wherein the absorbent material comprises a hollow, cylinder of absorbent material.

3. The cartridge of claim **1**, wherein the absorbent material comprises glass fiber.

4. The cartridge of claim **1**, further comprising:

a sheath integrally formed with an inner tube, the sheath at least partially surrounding the absorbent material, the sheath including an end wall, the end wall including at least one weep hole through the end wall, the absorbent material in fluid communication with the reservoir via the at least one weep hole.

5. The cartridge of claim **4**, further comprising:

a cylindrical member extending through the first connector piece, the cylindrical member electrically isolated from the post, the cylindrical member formed of a conductive material, and the cylindrical member in contact with at least a portion of the sheath.

6. The cartridge of claim **4**, wherein the sheath is formed of an electrically conductive material.

7. The cartridge of claim **6**, wherein the first end of the heater is in contact with a portion of the sheath.

8. The cartridge of claim **7**, wherein the sheath is electrically insulated from the post.

9. The cartridge of claim **4**, wherein the housing comprises:

an end wall that is integrally formed with the housing, the end wall including a channel therethrough, the channel in fluid communication with an air channel extending through the inner tube.

10. The cartridge of claim **9**, further comprising:

a mouthpiece configured to fit over a first end of the housing, the mouthpiece including at least one outlet in fluid communication with the channel in the end wall.

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11. The cartridge of claim **2**, wherein the housing comprises:

a support tube attached to an inner wall of the housing by at least two fins, spaces between the fins forming part of the reservoir.

12. The cartridge of claim **11**, wherein a first end of an inner tube fits with an end portion of the support tube.

13. A cartridge of an e-vaping device, the cartridge comprising:

a housing extending in a longitudinal direction;

a reservoir in the housing, the reservoir configured to store a pre-vapor formulation;

an inner tube in the housing, the reservoir between an inner surface of the housing and an outer surface of the inner tube, the inner tube defining an air channel therein;

a sheath integrally formed with the inner tube, the sheath having an end wall and a lateral wall, the sheath defining a heating chamber therein, the sheath defining an air passage through the end wall, and the air passage in fluid communication with the air channel;

a gasket portion within the sheath, the gasket portion including a base portion and an elongate portion, the base portion friction fitted within the lateral wall of the sheath and the elongate portion extending out of the sheath;

a heating coil in the heating chamber;

a wick in contact with the heating coil; and

an absorbent material surrounding a portion of the elongate portion of the gasket portion, the absorbent material within the sheath and in contact with the wick.

14. The cartridge of claim **13**, wherein the gasket portion defines two holes through the base portion and the cartridge further comprises:

a first electrical lead; and

a second electrical lead, each of the first electrical lead and the second electrical lead extending through one of the two holes through the base portion of the gasket portion.

15. The cartridge of claim **13**, wherein the gasket portion defines at least one flow passage through the base portion and the elongate portion, the at least one flow passage in fluid communication with the air passage and the air channel.

16. The cartridge of claim **13**, wherein the gasket portion defines at least one notch through the base portion and at least one end of the wick extends through the at least one notch.

17. The cartridge of claim **13**, wherein the gasket portion is integrally molded with a connector piece.

18. The cartridge of claim **13**, wherein the absorbent material is in fluid communication with the reservoir.

19. A cartridge of an e-vaping device, the cartridge comprising:

a housing extending in a longitudinal direction;

a reservoir in the housing, the reservoir configured to store a pre-vapor formulation;

an inner tube in the housing, the reservoir between an inner surface of the housing and an outer surface of the inner tube, the inner tube defining an air channel therein;

a sheath integrally formed with the inner tube, the sheath having an end wall and a lateral wall, the sheath defining a chamber within the lateral wall, the sheath defining an air passage through the end wall, the air passage in fluid communication with the air channel;

a heater in the chamber; and

an absorbent material within a portion of the sheath.

20. The cartridge of claim 19, wherein the heater comprises:

- a first ring at a first end of the heater,
- a second ring at a second end of the heater, and
- a sinusoidal shaped member extending between the first 5
ring and the second ring, and the first ring, the sinusoidal shaped member, and the second ring being integrally formed.

21. The cartridge of claim 20, wherein the heater is a coiled heater. 10

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